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Gopalan et al.

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(54) **CUP-SHAPED NOZZLE ASSEMBLY WITH INTEGRAL FILTER STRUCTURE**

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Related U.S. Application Data

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(51) **Int. Cl.**

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B05B 1/08	(2006.01)
B05B 15/00	(2006.01)
B05B 11/00	(2006.01)
B65D 83/14	(2006.01)
B65D 83/20	(2006.01)
F15B 21/12	(2006.01)
B65D 83/28	(2006.01)
F15C 1/22	(2006.01)

(52) **U.S. Cl.**

CPC ***B05B 1/08*** (2013.01); ***B05B 15/008*** (2013.01); ***B05B 1/14*** (2013.01); ***B05B 11/3011*** (2013.01); ***B65D 83/14*** (2013.01); ***B65D 83/20*** (2013.01); *Y10S 239/23* (2013.01); ***B65D 83/753*** (2013.01); ***F15B 21/12*** (2013.01); ***B65D 83/28*** (2013.01); ***F15C 1/22*** (2013.01)

(58) **Field of Classification Search**

CPC B05B 1/08; B05B 11/3011; B05B 1/14; B05B 15/008; B65D 83/28; B65D 83/753; B65D 83/20; B65D 83/14; B65D 83/38; B65D 83/205; Y10S 239/23; F15B 21/12; F15C 1/22

USPC .... 239/333, 337, 462, 491, 492, 239/553–553.5, 575, 590–590.5, DIG. 23; 222/402.1, 402.13

See application file for complete search history.

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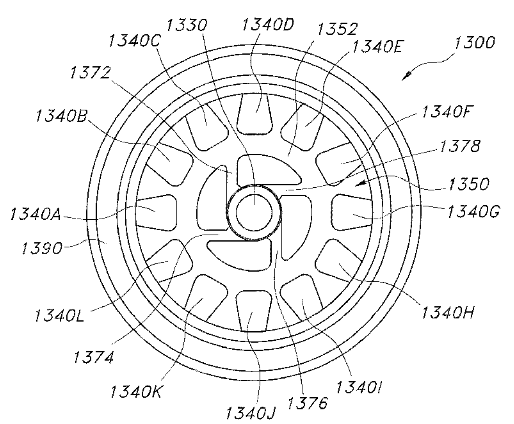
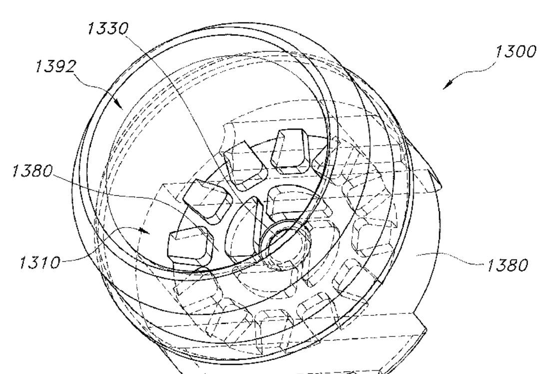
(57) **ABSTRACT**

A filtering nozzle assembly or spray head has a conformal nozzle component engineered to generate a filtered spray and configured as a small cylindrical member having a substantially open proximal end and a substantially closed distal end wall with a centrally located discharge orifice defined therein. Optionally, cup-shaped filtered orifice defining member also includes a fluidic circuit's oscillation inducing geometry molded into the cup or directly into the distal surface of a sealing post and the one-piece filter cup provides the fluidic circuit's discharge orifice.

16 Claims, 18 Drawing Sheets





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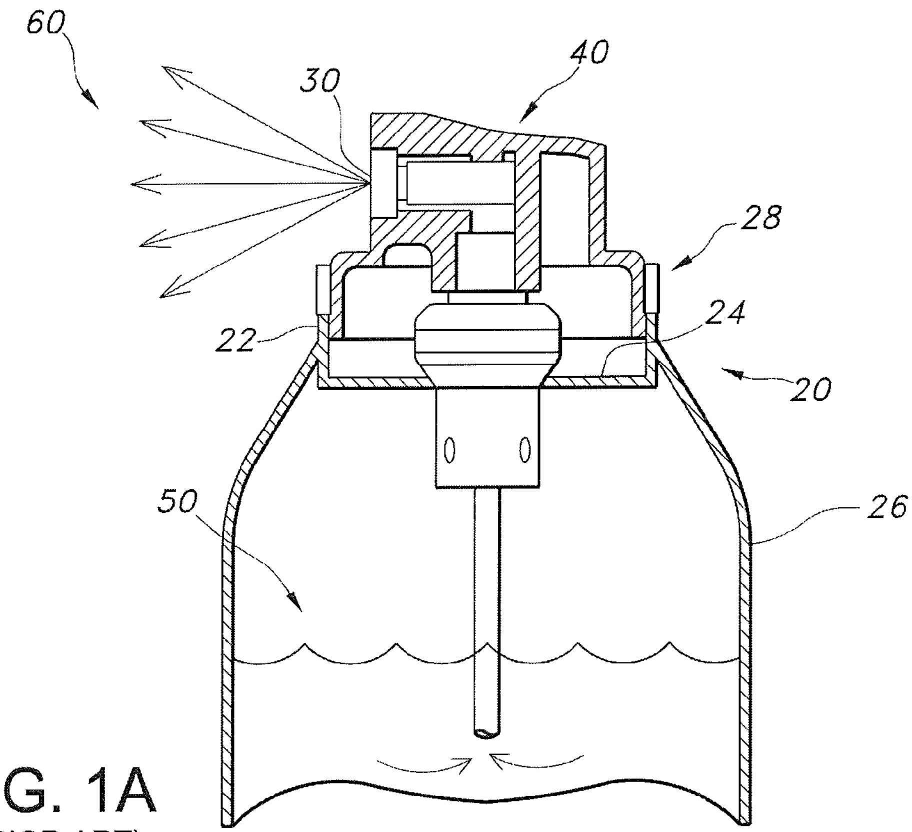


FIG. 1A
(PRIOR ART)

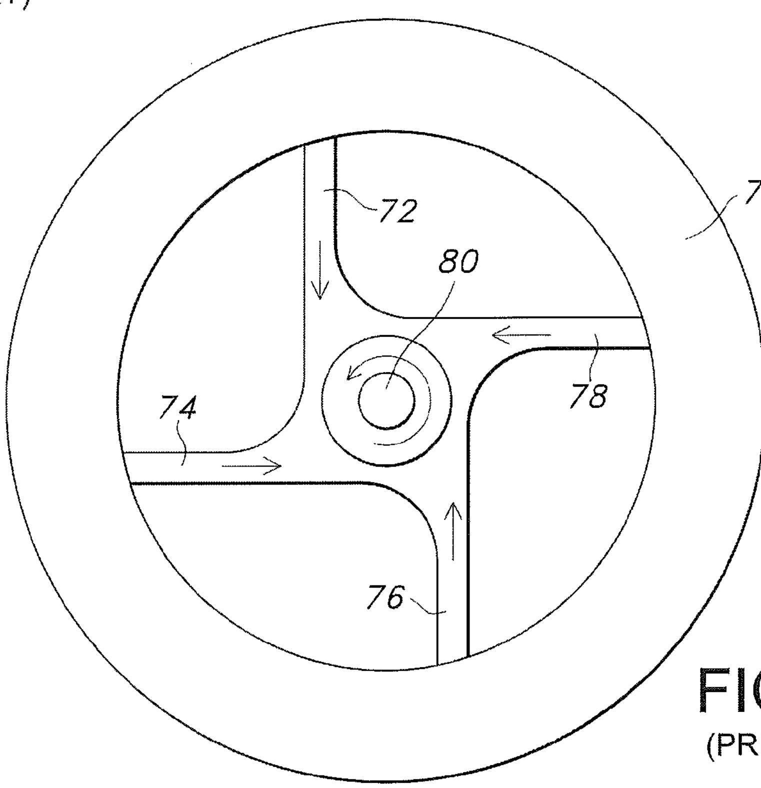


FIG. 1B
(PRIOR ART)

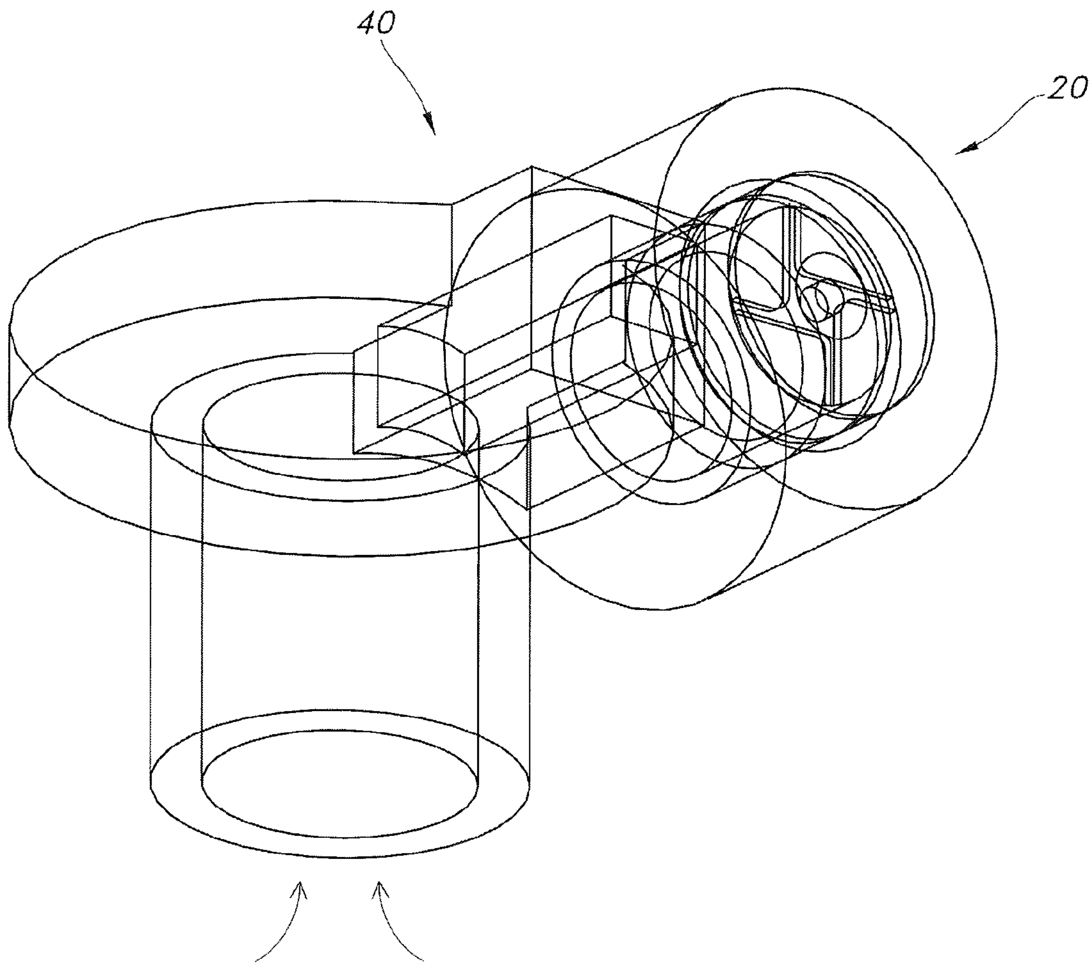


FIG. 2
(PRIOR ART)

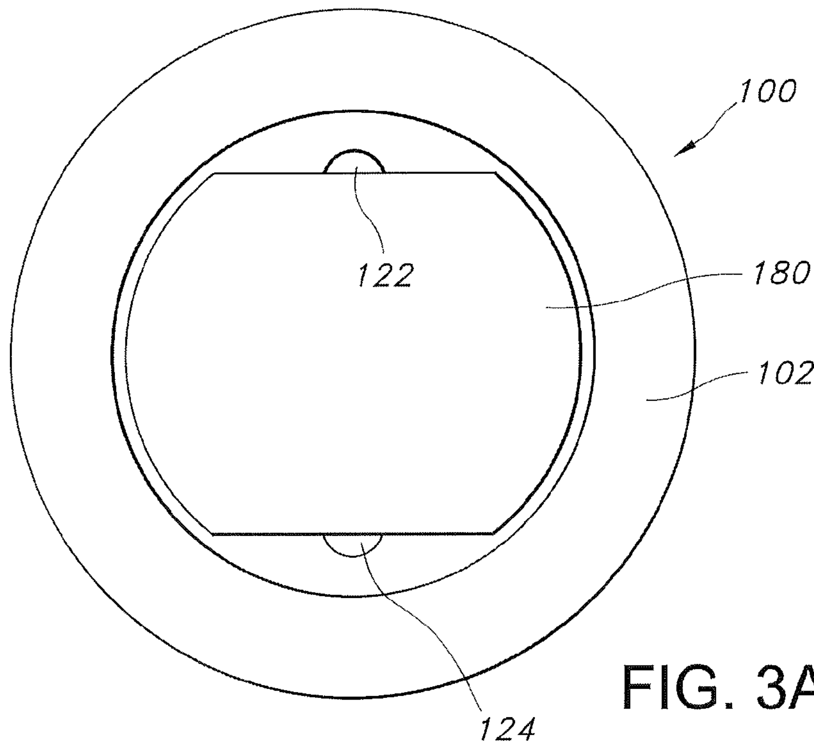


FIG. 3A

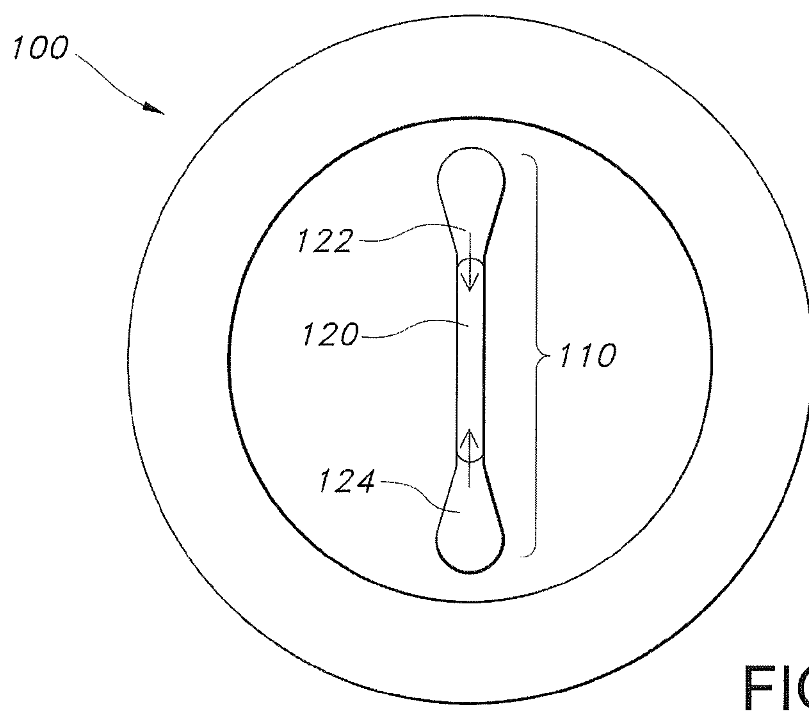


FIG. 3B

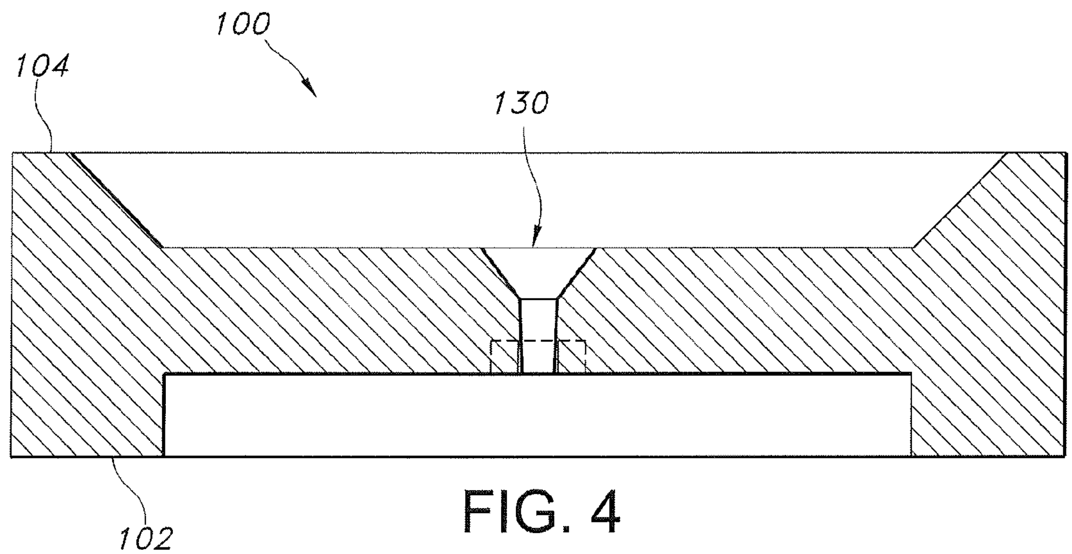


FIG. 4

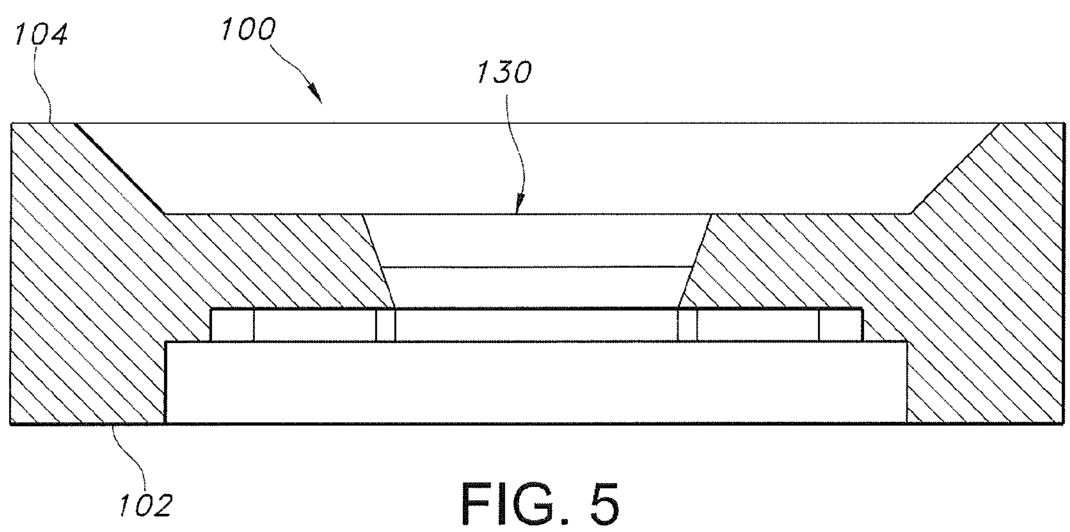


FIG. 5

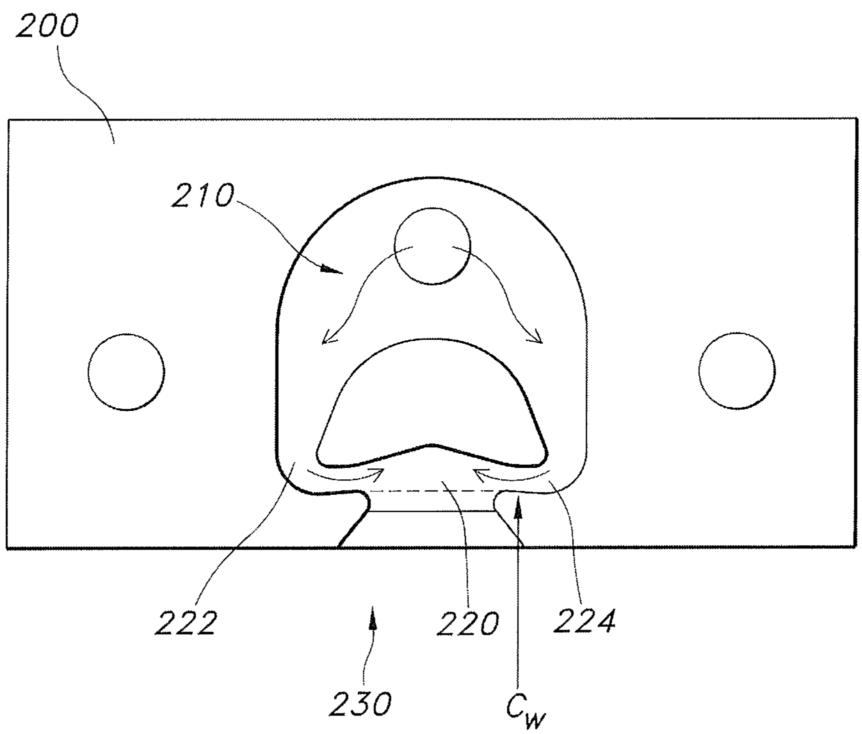


FIG. 6

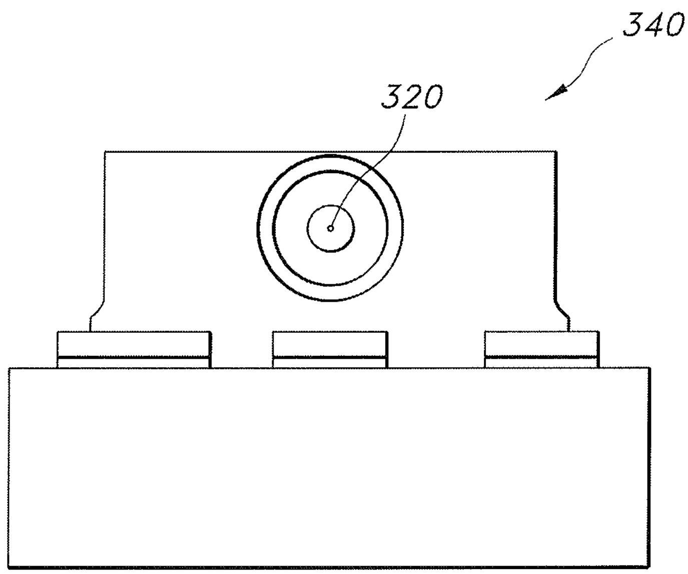


FIG. 7A

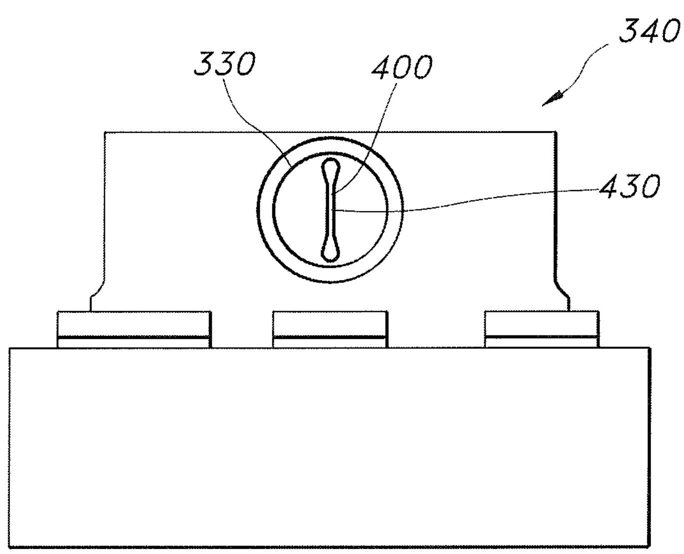


FIG. 7B

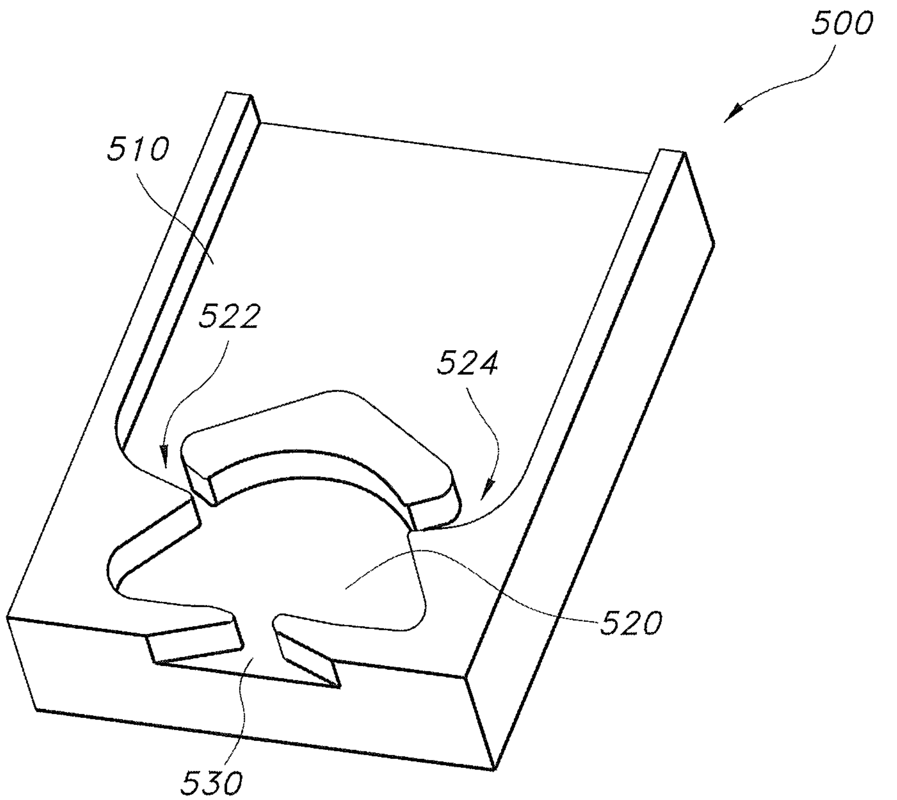


FIG. 8

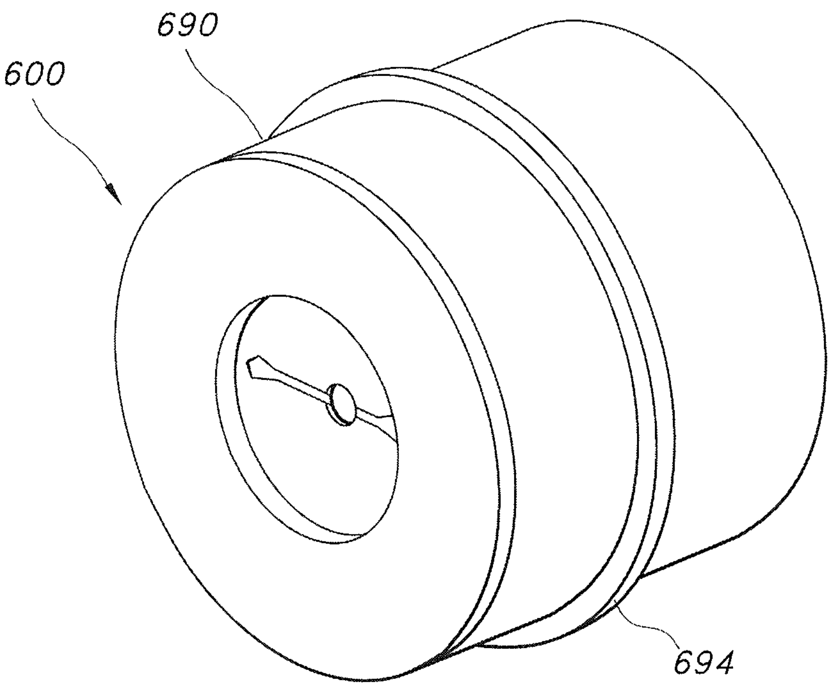


FIG. 9A

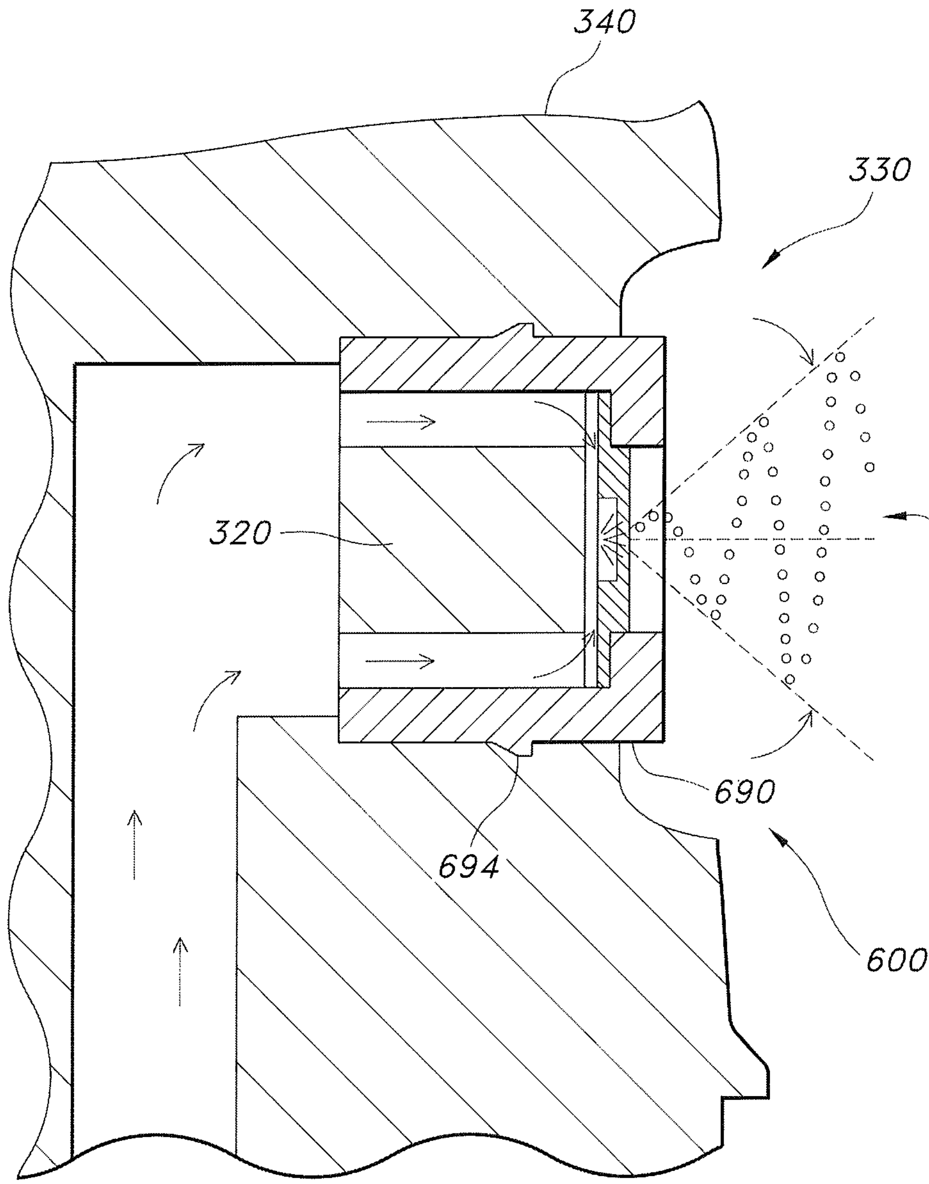


FIG. 9B

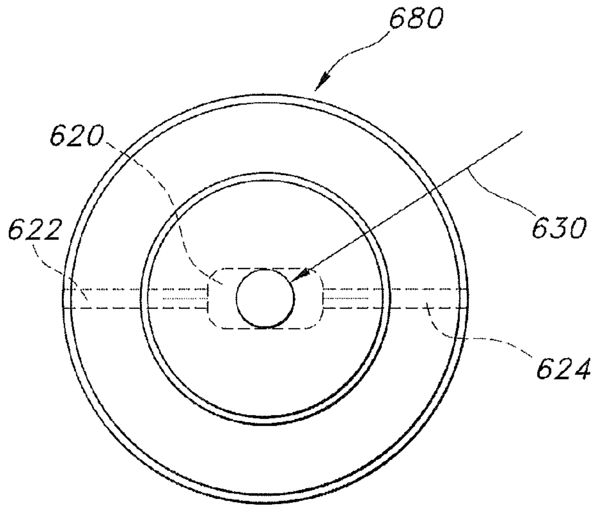


FIG. 10A

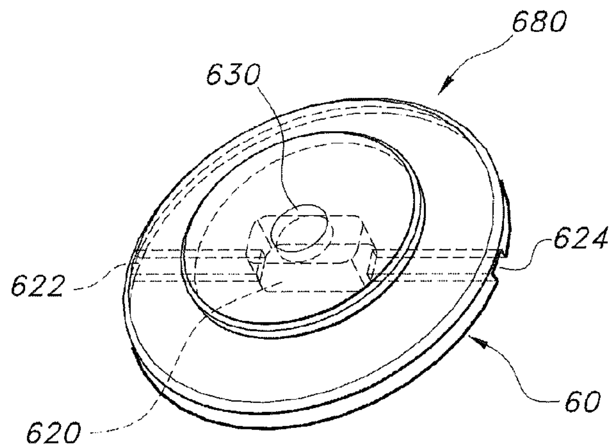


FIG. 10C

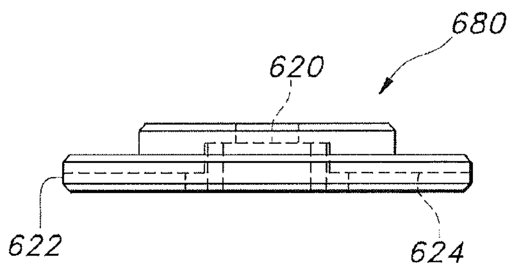


FIG. 10B

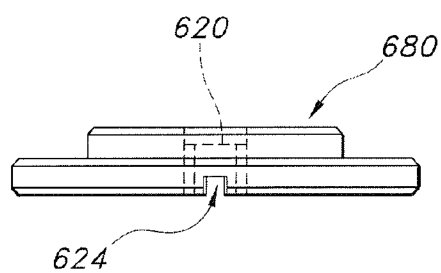


FIG. 10D

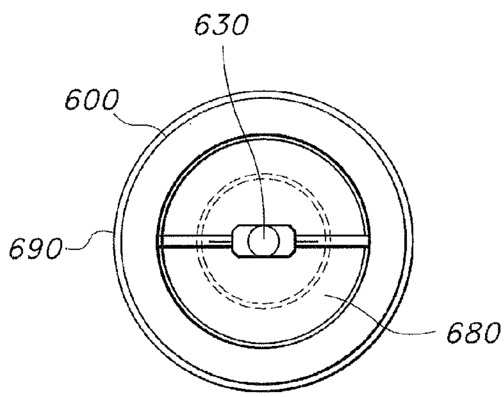


FIG. 11A

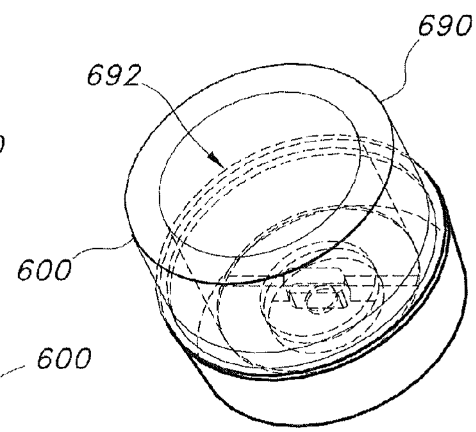


FIG. 11C

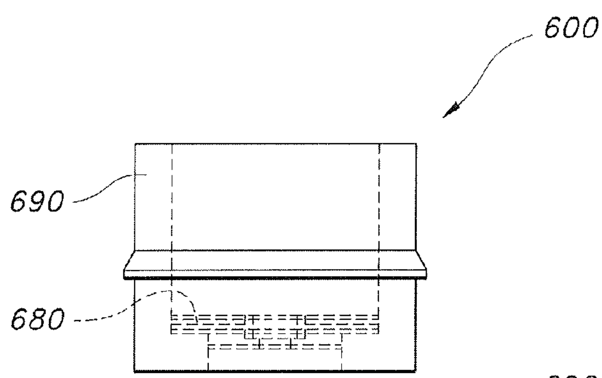


FIG. 11B

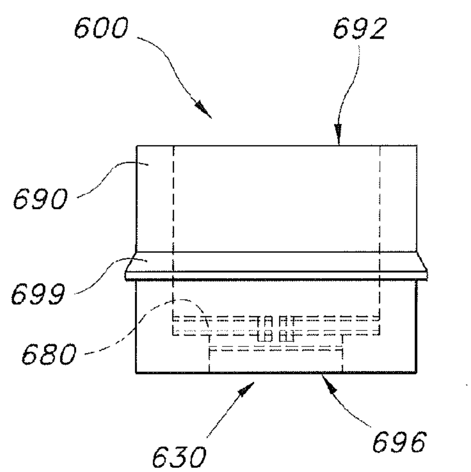


FIG. 11D

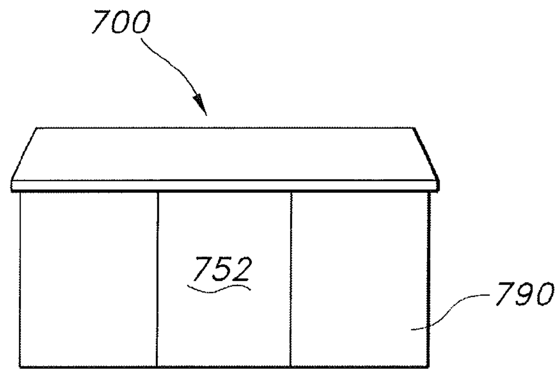


FIG. 12D

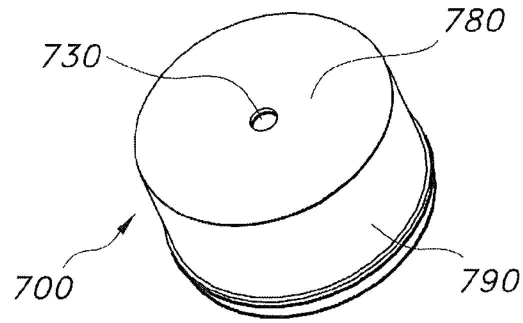


FIG. 12E

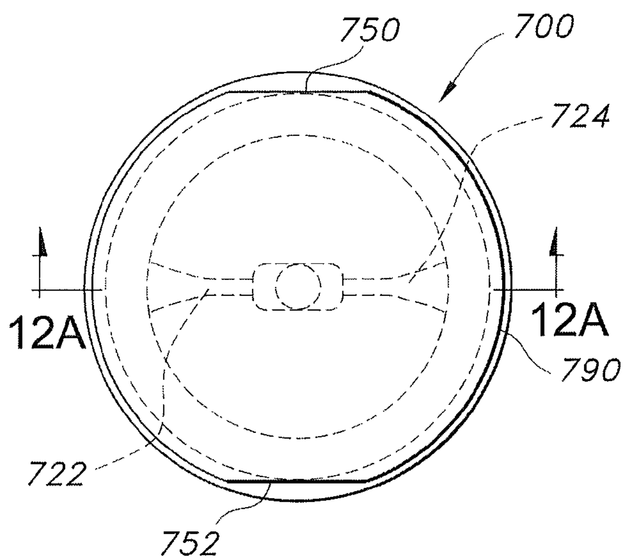


FIG. 12C

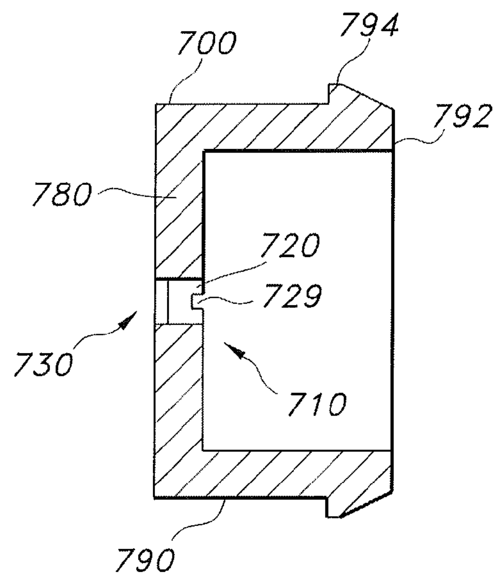


FIG. 12B

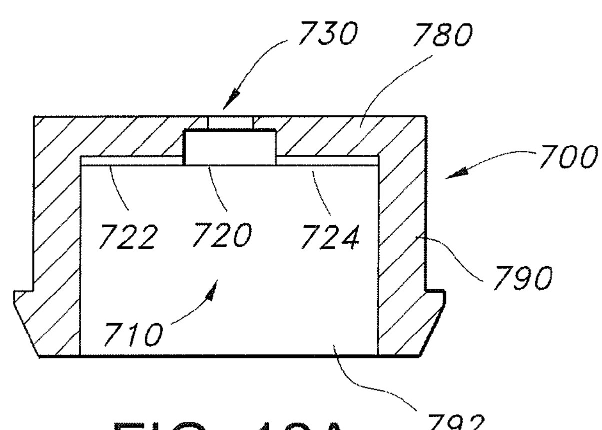


FIG. 12A

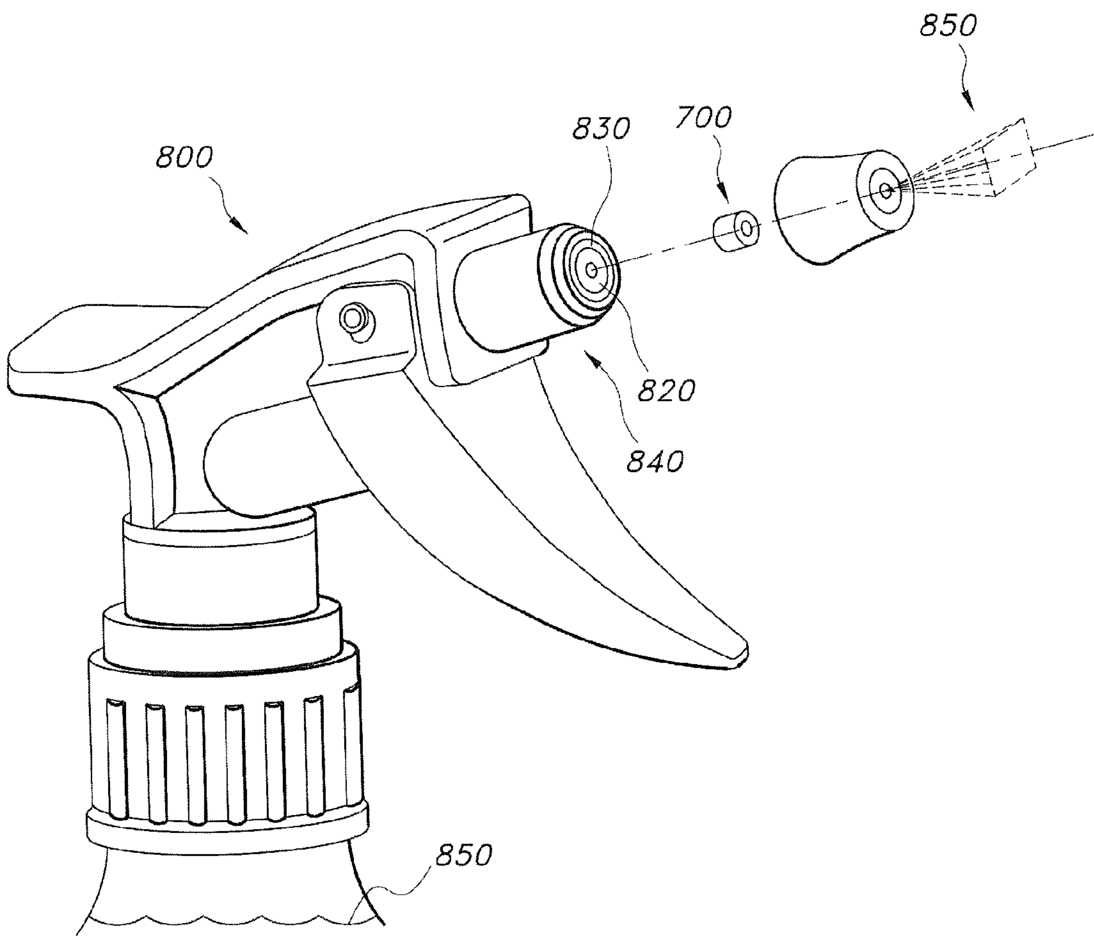
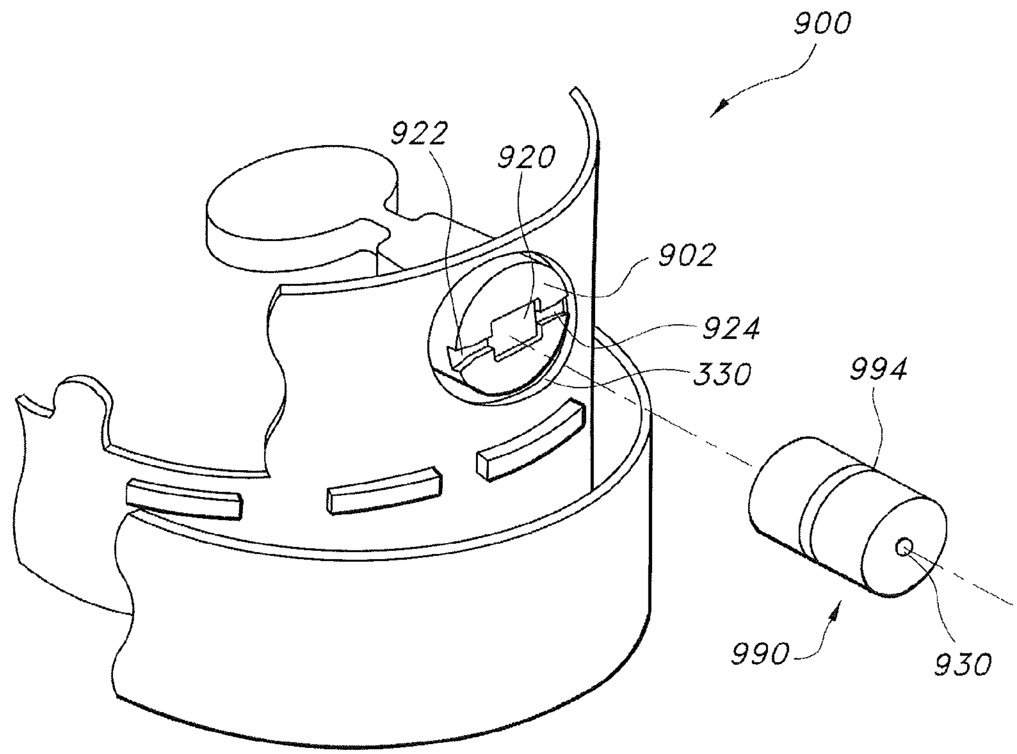


FIG. 13


900
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924
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994
990
930

FIG. 14

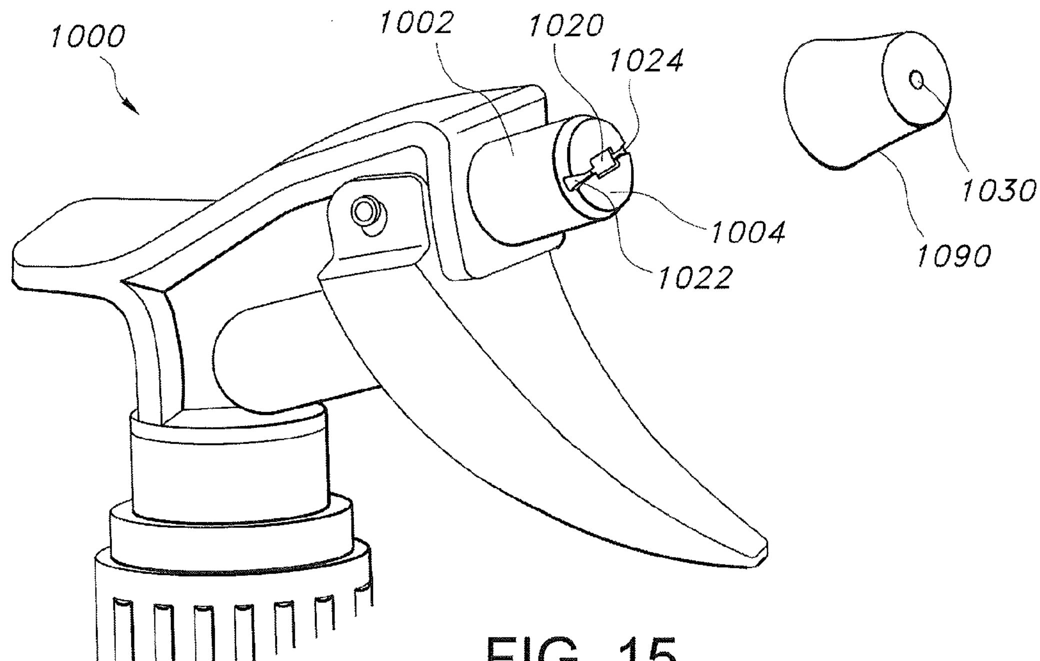
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FIG. 15

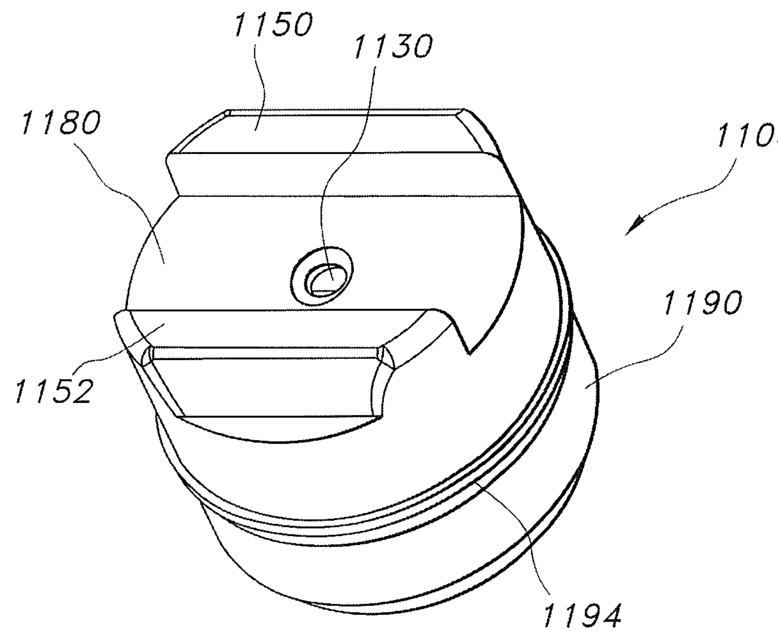
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FIG. 16

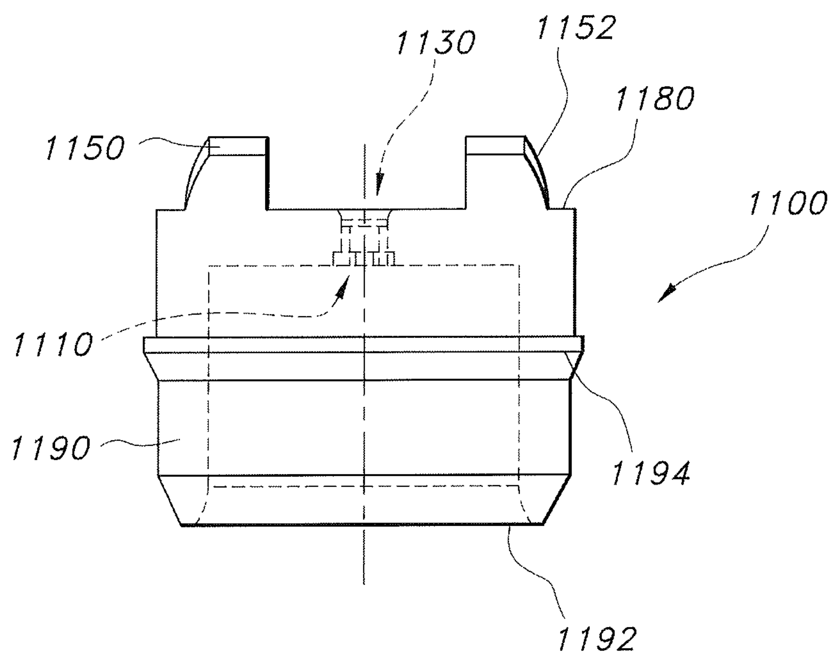
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FIG. 17

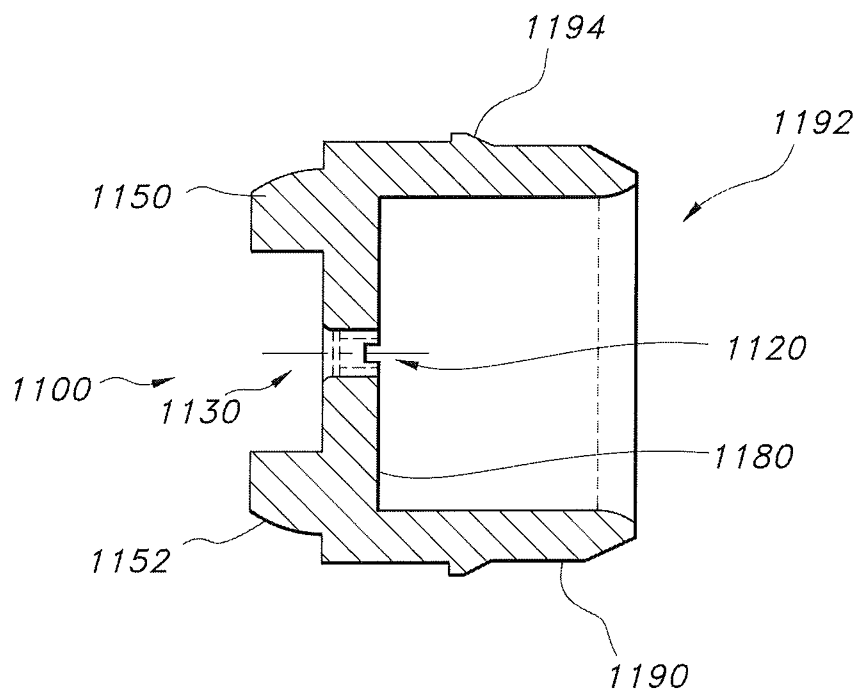

FIG. 18

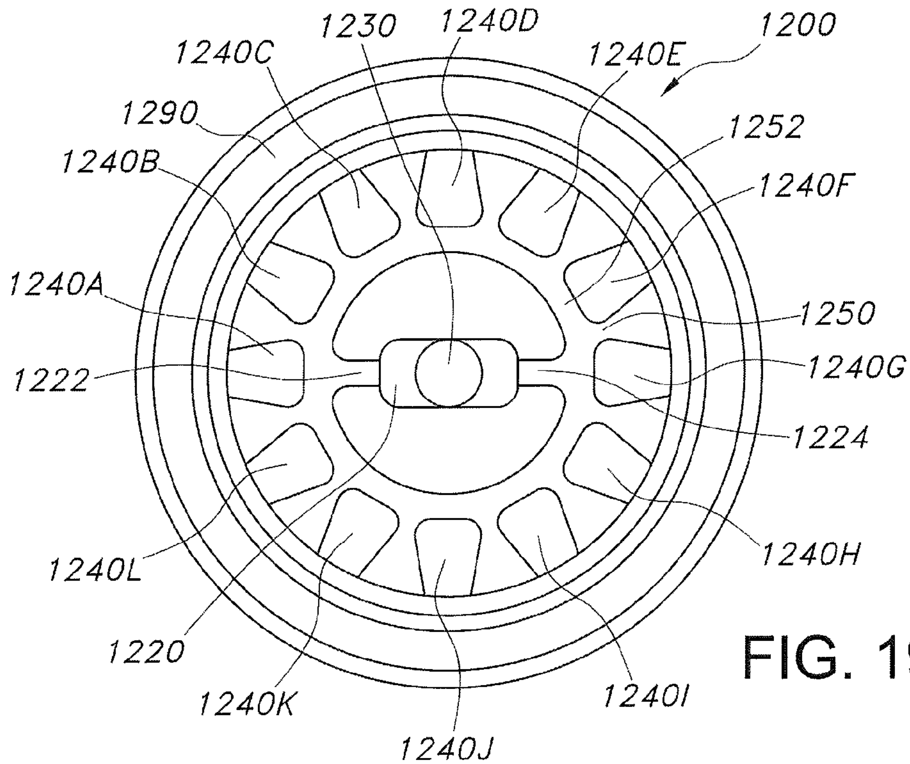

FIG. 19A

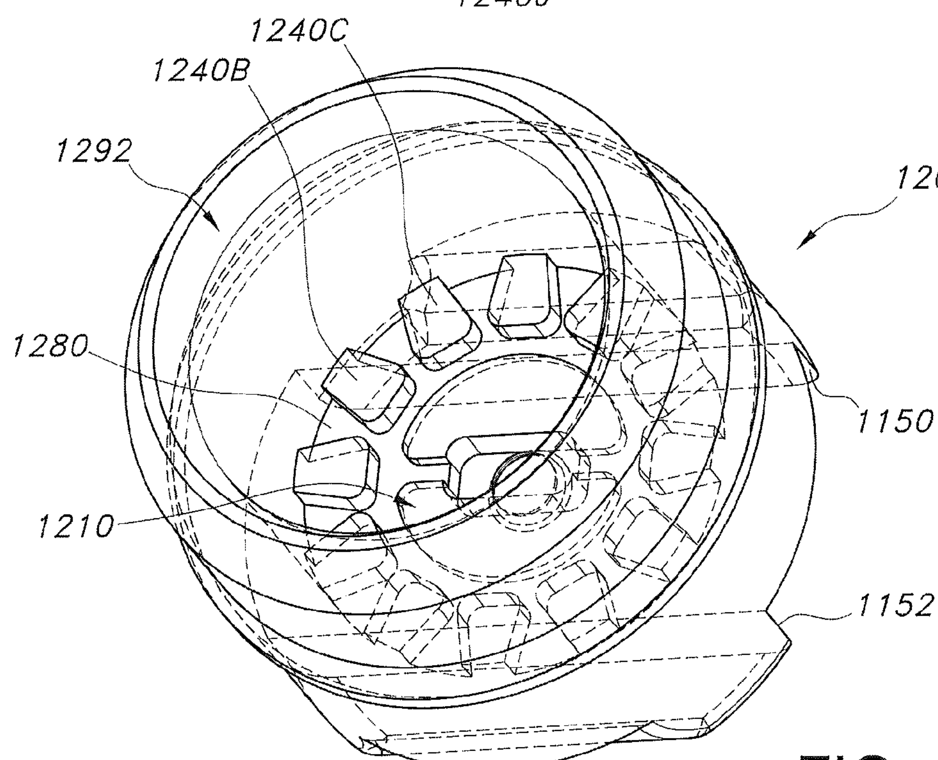

FIG. 19B

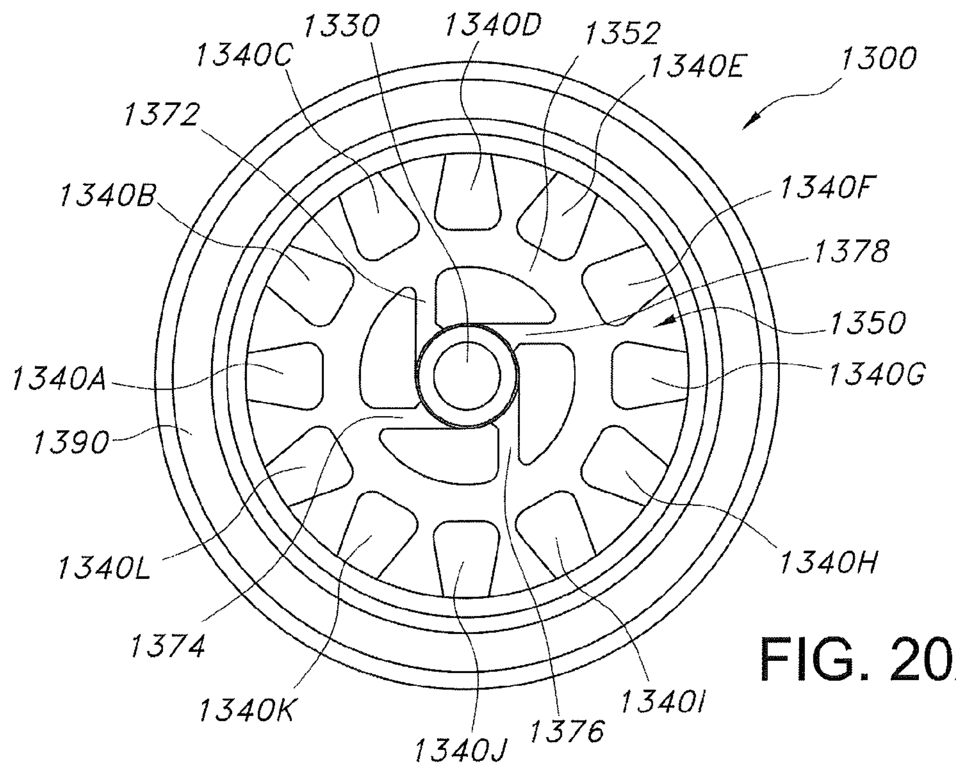

FIG. 20A

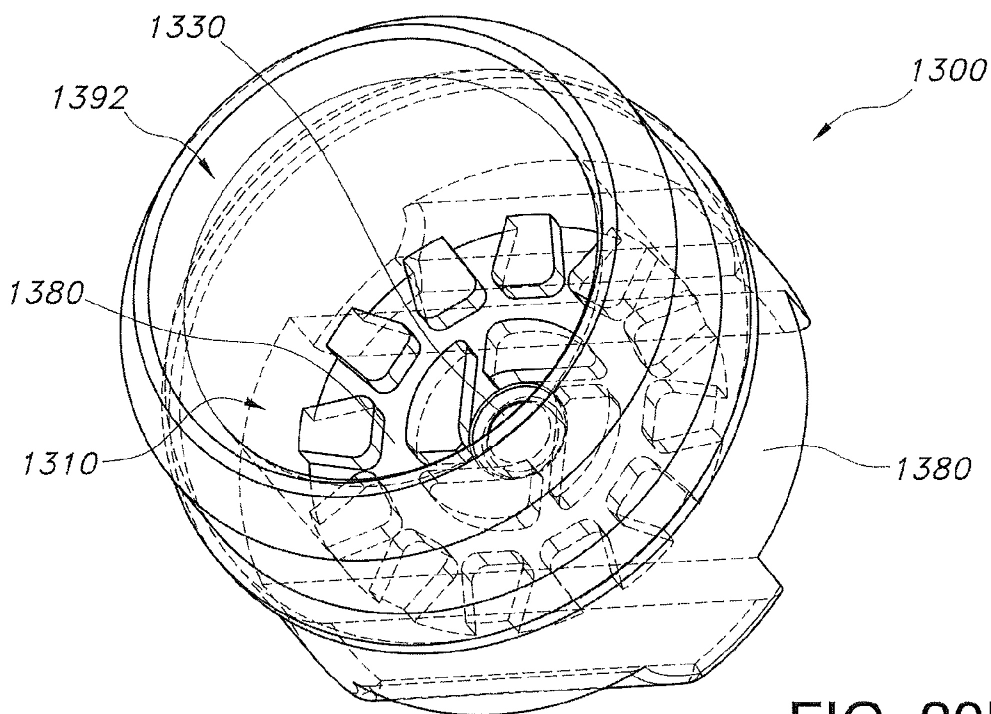

FIG. 20B

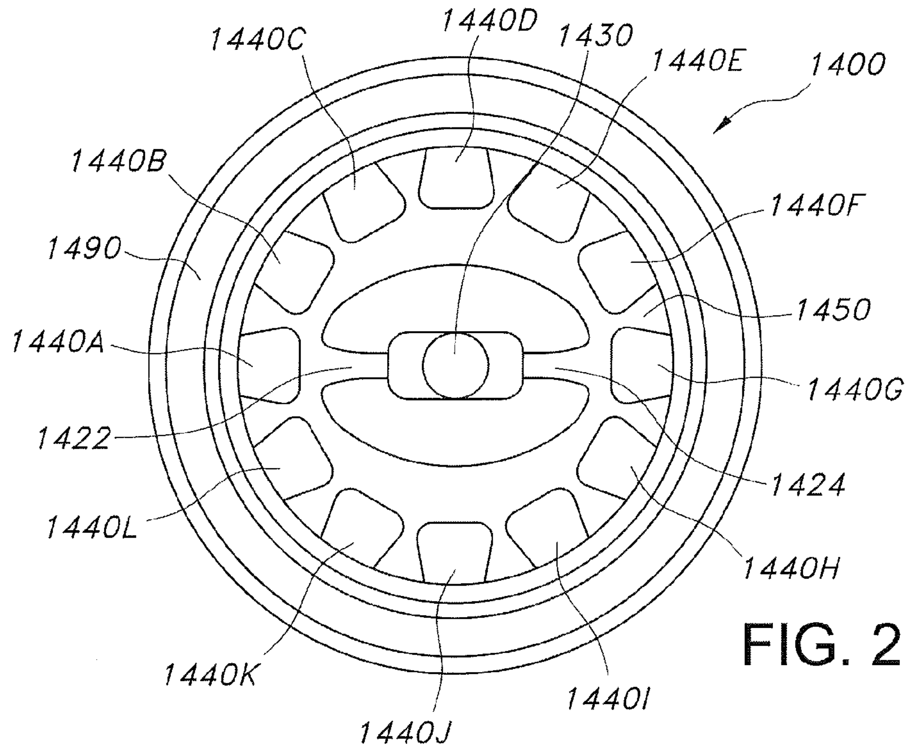

FIG. 21A

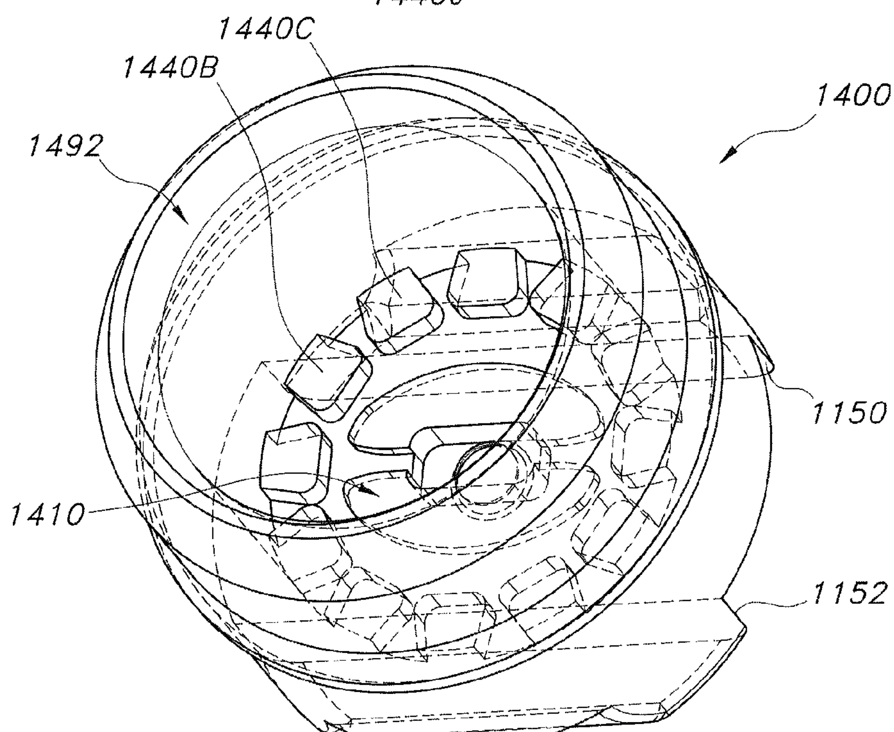

FIG. 21B

CUP-SHAPED NOZZLE ASSEMBLY WITH INTEGRAL FILTER STRUCTURE

REFERENCE TO RELATED APPLICATIONS

This application claims priority to commonly owned U.S. provisional patent application No. 61/806,680, filed Mar. 29, 2013 and entitled Cup-shaped nozzle assembly with integral filter Structure, the entire disclosure of which is incorporated by reference. This application is also related to commonly owned U.S. provisional patent application No. 61/476,845, filed Apr. 19, 2011 and entitled Method and Fluidic Cup apparatus for creating 2-D or 3-D spray patterns, as well as PCT application number PCT/US12/34293, filed Apr. 19, 2012 and entitled Cup-shaped Fluidic Circuit, Nozzle Assembly and Method (WIPO Pub WO 2012/145537), co-pending U.S. application Ser. No. 13/816,661, filed Feb. 12, 2013, and co-pending U.S. application Ser. No. 13/840,981, filed Mar. 15, 2013 and entitled Cup-shaped Fluidic Circuit with Alignment Tabs, Nozzle Assembly and Method, the entire disclosures of which are incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates generally to transportable or disposable liquid or fluid product dispensers and nozzle assemblies adapted for use with liquid or fluid product sprayers, and more particularly to such sprayers having nozzle assemblies configured for dispensing or generating sprays of selected fluids or liquid products in a desired spray pattern.

2. Discussion of the Prior Art

Cleaning fluids, hair spray, skin care products and other liquid products are often dispensed from disposable, pressurized or manually actuated sprayers which can generate a roughly conical spray pattern or a straight stream. Some dispensers or sprayers have an orifice cup with a discharge orifice through which product is dispensed or applied by sprayer actuation. For example, the manually actuated sprayer of U.S. Pat. No. 6,793,156 to Dobbs, et al illustrates an improved orifice cup mounted within the discharge passage of a manually actuated hand-held sprayer. The cup is held in place with its cylindrical side wall press fitted within the wall of a circular bore. Dobbs' orifice cup includes "spin mechanics" in the form of a spin chamber and spinning or tangential flows there are formed on the inner surface of the circular base wall of the orifice cup. Upon manual actuation of the sprayer, pressures are developed as the liquid product is forced through a constricted discharge passage and through the spin mechanics before issuing through the discharge orifice in the form of a traditional conical spray. If the liquid product is susceptible to congealing or clogging, the spray is often not consistent and unsatisfactory, especially when first spraying the product, or during "start-up."

If no spin mechanics are provided or if the spin mechanics feature is immobilized (e.g., due to product clogging), the liquid issues from the discharge orifice in the form of a stream. Typical orifice cups are molded with a cylindrical skirt wall, and an annular retention bead projects radially outwardly of the side of the cup near the front or distal end thereof. The orifice cup is typically force fitted within a cylindrical bore at the terminal end of a discharge passage in tight frictional engagement between the cylindrical side wall of the cup and the cylindrical bore wall. The annular retention bead is designed to project into the confronting cylindrical portion of the pump sprayer body serving to assist in retaining the orifice cup in place within the bore as well as in acting as a seal between the orifice cup and the bore of the discharge passage. The spin mechanics feature is formed on the inner surface of the base of the orifice cup to provide a swirl cup which functions to swirl the fluid or liquid product and break it up into a substantially conical spray pattern.

Manually pumped trigger sprayer of U.S. Pat. No. 5,114,052 to Tiramani, et al illustrates a trigger sprayer having a molded spray cap nozzle with radial slots or grooves which swirl the pressurized liquid to generate an atomized spray from the nozzle's orifice.

Other spray heads or nebulizing nozzles used in connection with disposable, manually actuated sprayers are incorporated into propellant pressurized packages including aerosol dispensers such as is described in U.S. Pat. No. 4,036,439 to Green and U.S. Pat. No. 7,926,741 to Laidler et al. All of these spray heads or nozzle assemblies include a swirl system or swirl chamber which work with a dispensing orifice via which the fluid is discharged from the dispenser member. The recesses, grooves or channels defining the swirl system cooperate with the nozzle to entrain the dispensed liquid or fluid in a swirling movement before it is discharged through the dispensing orifice. The swirl system is conventionally made up of one or more tangential swirl grooves, troughs, passages or channels opening out into a swirl chamber accurately centered on the dispensing orifice. The swirled, pressurized fluid is swirled and discharged through the dispensing orifice. U.S. Pat. No. 4,036,439 to Green describes a cup-shaped insert with a discharge orifice which fits over a projection having the grooves defined in the projection, so that the swirl cavity is defined between the projection and the cup-shaped insert. These swirl cavities only work when the liquid product flows evenly, however, and if the liquid product is susceptible to congealing or clogging, the spray is often not consistent and unsatisfactory, especially when first spraying the product, or during "start-up."

All of these nozzle assembly or spray-head structures with swirl chambers are configured to generate substantially conical atomized or nebulized sprays of fluid or liquid in a continuous flow over the entire spray pattern, and droplet sizes are poorly controlled, often generating "fines" or nearly atomized droplets. Other spray patterns (e.g., a narrow oval which is nearly linear) are possible, but the control over the spray's pattern is limited. None of these prior art swirl chamber nozzles can generate an oscillating spray of liquid or provide precise sprayed droplet size control or spray pattern control. There are several consumer products packaged in aerosol sprayers and trigger sprayers where it is desirable to provide customized, precise liquid product spray patterns.

Oscillating fluidic sprays have many advantages over conventional, continuous sprays, and can be configured to generate an oscillating spray of liquid or provide a precise sprayed droplet size control or precisely customized spray pattern for a selected liquid or fluid. The applicants have been approached by liquid product makers who want to provide those advantages, but the prior art fluidic nozzle assemblies have not been configured for incorporation with disposable, manually actuated sprayers.

In applicants' durable and precise prior art fluidic circuit nozzle configurations, a fluidic nozzle is constructed by assembling a planar fluidic circuit or insert in to a weatherproof housing having a cavity that receives and aims the fluidic insert and seals the flow passage. A good example of a fluidic oscillator equipped nozzle assembly as used in the automotive industry is illustrated in commonly owned U.S. Pat. No. 7,267,290 (see, e.g., FIG. **3**) which shows how the planar fluidic circuit insert is received within and aimed by the housing.

Fluidic circuit generated sprays could be very useful in disposable, manually actuated sprayers, but adapting the fluidic circuits and fluidic circuit nozzle assemblies of the prior art would cause additional engineering and manufacturing process changes to the currently available disposable, manually actuated sprayers, thus making them too expensive to produce at a commercially reasonable cost. If the liquid product is susceptible to congealing or clogging, the prior art fluidic oscillator configurations would also prove unsatisfactory, especially when first spraying the product, or during "start-up."

There is a need, therefore, for a commercially reasonable and inexpensive, disposable, manually actuated sprayer or nozzle assembly which overcomes the problems with the prior art, especially for applications where the product is susceptible to congealing or clogging.

OBJECTS AND SUMMARY OF THE INVENTION

Accordingly, it is an object of the present invention to overcome the above mentioned difficulties by providing a commercially reasonable inexpensive, disposable, manually actuated cup-shaped nozzle assembly with a filter adapted for use with an optional fluidic circuit which provides the advantages of filtered fluid sprays and controlled spray patterns of a selected liquid or fluid product.

In accordance with the present invention, a filtered cup nozzle does not require a multi-component insert and housing assembly. The filtered cup nozzle's features or fluid channel defining geometry are preferably molded directly into a cup-shaped member which is then affixed to a fluid product dispensing package's actuator. This eliminates the need for an assembly made from a fluidic circuit defining insert which is received within a housing cavity. The present invention provides a novel filter cup with, optionally, a fluidic circuit which functions like a planar fluidic circuit but which has the fluidic circuit's oscillation inducing features configured within a cup-shaped member.

The filtered cup is useful with both hand-pumped trigger sprayers and propellant filled aerosol sprayers and can be configured to generate different sprays for different liquid or fluid products. A filtered swirl-cup or filtered fluidic cup can be configured to project a desired spray pattern (e.g., a 3-D or rectangular oscillating pattern of uniform droplets). The filtered swirl cup nozzle reliably overcomes the start-up spray clogging problems for liquid products which would otherwise clog the nozzle, and the same clog resistance benefit is provided by the fluidic oscillator equipped cup embodiments. The fluidic oscillator structure's fluid dynamic mechanism for generating the oscillation is conceptually similar to that shown and described in commonly owned U.S. Pat. Nos. 7,267,290 and 7,478,764 (Gopalan et al) which describe a planar mushroom fluidic circuit's operation; both of these patents are incorporated herein in their entireties.

In the exemplary embodiments illustrated herein, a mushroom-equivalent fluidic cup oscillator carries an annular retention bead which projects radially outwardly of the side of the cup near the front or distal end thereof. The fluidic cup is typically force fitted within an actuator's cylindrical bore at the terminal end of a discharge passage in tight frictional engagement between the cylindrical side wall of the cup and the cylindrical bore wall of the actuator. The annular retention bead is designed to project into a confronting cylindrical groove or trough retaining portion of the actuator or pump sprayer body serving to assist in retaining the fluidic cup in place within the bore as well as in acting as a seal between the fluidic cup and the bore of the discharge passage. The fluidic oscillator features or geometry are formed on the inner surface(s) of the fluidic cup to provide a fluidic oscillator which functions to generate an oscillating pattern of droplets of uniform, selected size.

The novel fluidic circuit of the present invention is a conformal, one-piece, molded fluidic cup. There are several consumer applications like aerosol sprayers and trigger sprayers where it is desirable to customize sprays. Fluidic sprays are very useful in these cases but adapting typical commercial aerosol sprayers and trigger sprayers to accept the standard fluidic oscillator configurations would cause unreasonable product manufacturing process changes to current aerosol sprayers and trigger sprayers thus making them much more expensive. The fluidic cup and method of the present invention conforms to the actuator stem used in typical aerosol sprayers and trigger sprayers and so replaces the prior art "swirl cup" that goes over the actuator stem, and the benefits of using a fluidic oscillator are made available with little or no significant changes to other parts. With the fluidic cup and method of the present invention, vendors of liquid products and fluids sold in commercial aerosol sprayers and trigger sprayers can now provide very specifically tailored or customized sprays.

A nozzle assembly or spray head including a lumen or duct for dispensing or spraying a pressurized liquid product or fluid from a valve, pump or actuator assembly draws from a disposable or transportable container to generate an oscillating spray of very uniform fluid droplets. The fluidic cup nozzle assembly includes an actuator body having a distally projecting sealing post having a post peripheral wall terminating at a distal or outer face, and the actuator body includes a fluid passage communicating with the lumen.

A cup-shaped fluidic circuit is mounted in the actuator body member having a peripheral wall extending proximally into a bore in the actuator body radially outwardly of said sealing post and having a distal radial wall comprising an inner face opposing the sealing post's distal or outer face to define a fluid channel including a chamber having an interaction region between the body's sealing post and the cup-shaped fluidic circuit's peripheral wall and distal wall. The chamber is in fluid communication with the actuator body's fluid passage to define a fluidic circuit oscillator inlet so the pressurized fluid can enter the fluid channel's chamber and interaction region. The fluidic cup structure has a fluid inlet within the cup's proximally projecting cylindrical sidewall, and the exemplary fluid inlet is substantially annular and of constant cross section, but the fluidic cup's fluid inlet can also be tapered or include step discontinuities (e.g., with an abruptly smaller or stepped inside diameter) to enhance the pressurized fluid's instability.

The cup-shaped fluidic circuit distal wall's inner face either supports an insert with or carries the fluidic geometry, so it is configured to define the fluidic oscillator's operating features or geometry within the chamber. It should be emphasized that any fluidic oscillator geometry which defines an interaction region to generate an oscillating spray of fluid droplets can be used, but, for purposes of illustration, conformal cup-shaped fluidic oscillators having two exemplary fluidic oscillator geometries will be described in detail.

For a conformal cup-shaped fluidic oscillator embodiment which emulates the fluidic oscillation mechanisms of a planar mushroom fluidic oscillator circuit, the conformal fluidic cup's chamber includes a first power nozzle and second power nozzle, where the first power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the first nozzle to form a first jet of fluid flowing into the chamber's interaction region, and the second power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the second nozzle to form a second jet of fluid flowing into the chamber's interaction region. The first and second jets impinge upon one another at a selected inter-jet impingement angle (e.g., 180 degrees, meaning the jets impinge from opposite sides) and generate oscillating flow vortices within the fluid channel's interaction region which is in fluid communication with a discharge orifice or power nozzle defined in the fluidic circuit's distal wall, and the oscillating flow vortices spray droplets through the discharge orifice as an oscillating spray of substantially uniform fluid droplets in a selected (e.g., rectangular) spray pattern having a selected spray width and a selected spray thickness.

The first and second power nozzles are preferably venturi-shaped or tapered channels or grooves in the cup-shaped fluidic circuit distal wall's inner face and terminate in a rectangular or box-shaped interaction region defined in the cup-shaped fluidic circuit distal wall's inner face. The interaction region could also be cylindrical, which affects the spray pattern.

The cup-shaped fluidic circuit's power nozzles, interaction region and throat can be defined in a disk or pancake shaped insert fitted within the cup, but are preferably molded directly into said cup's interior wall segments. When molded from plastic as a one-piece cup-shaped fluidic circuit, the fluidic cup is easily and economically fitted onto the actuator's sealing post, which typically has a distal or outer face that is substantially flat and fluid impermeable and in flat face sealing engagement with the cup-shaped fluidic circuit distal wall's inner face. The sealing post's peripheral wall and the cup-shaped fluidic circuit's peripheral wall are spaced axially to define an annular fluid channel and the peripheral walls are generally parallel with each other but may be tapered to aid in developing greater fluid velocity and instability.

As a fluidic circuit item for sale or shipment to others, the conformal, unitary, one-piece fluidic circuit is configured for easy and economical incorporation into a nozzle assembly or aerosol spray head actuator body including distally projecting sealing post and a lumen for dispensing or spraying a pressurized liquid product or fluid from a disposable or transportable container to generate an oscillating spray of fluid droplets. The fluidic cup includes a cup-shaped fluidic circuit member having a peripheral wall extending proximally and having a distal radial wall comprising an inner face with features defined therein and an open proximal end configured to receive an actuator's sealing post. The cup-shaped member's peripheral wall and distal radial wall have inner surfaces comprising a fluid channel including a chamber when the cup-shaped member is fitted to the actuator body's sealing post and the chamber is configured to define a fluidic circuit oscillator inlet in fluid communication with an interaction region so when the cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced, (e.g., by pressing the aerosol spray button and releasing the propellant), the pressurized fluid can enter the fluid channel's chamber and interaction region and generate at least one oscillating flow vortex within the fluid channel's interaction region.

The cup shaped member's distal wall includes a discharge orifice in fluid communication with the chamber's interaction region, and the chamber is configured so that when the cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via the actuator body, the chamber's fluidic oscillator inlet is in fluid communication with a first power nozzle and second power nozzle, and the first power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the first nozzle to form a first jet of fluid flowing into the chamber's interaction region, and the second power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the second nozzle to form a second jet of fluid flowing into the chamber's interaction region, and the first and second jets impinge upon one another at a selected inter-jet impingement angle and generate oscillating flow vortices within fluid channel's interaction region. As before, the chamber's interaction region is in fluid communication with the discharge orifice defined in said fluidic circuit's distal wall, and the oscillating flow vortices spray from the discharge orifice as an oscillating spray of substantially uniform fluid droplets in a selected spray pattern having a selected spray width and a selected spray thickness.

In the method of the present invention, liquid product manufacturers making or assembling a transportable or disposable pressurized package for spraying or dispensing a liquid product, material or fluid would first obtain or fabricate the conformal fluidic cup circuit for incorporation into a nozzle assembly or aerosol spray head actuator body which typically includes the standard distally projecting sealing post. The actuator body has a lumen for dispensing or spraying a pressurized liquid product or fluid from the disposable or transportable container to generate a spray of fluid droplets, and the conformal fluidic circuit includes the cup-shaped fluidic circuit member having a peripheral wall extending proximally and having a distal radial wall comprising an inner face with features defined therein and an open proximal end configured to receive the actuator's sealing post. The cup-shaped member's peripheral wall and distal radial wall have inner surfaces comprising a fluid channel including a chamber with a fluidic circuit oscillator inlet in fluid communication with an interaction region; and the cup shaped member's peripheral wall preferably has an exterior surface carrying a transversely projecting snap-in locking flange.

In the preferred embodiment of the assembly method, the product manufacturer or assembler next provides or obtains an actuator body with the distally projecting sealing post centered within a body segment having a snap-fit groove configured to resiliently receive and retain the cup shaped member's transversely projecting locking flange. The next step is inserting the sealing post into the cup-shaped member's open distal end and engaging the transversely projecting locking flange into the actuator body's snap fit groove to enclose and seal the fluid channel with the chamber and the fluidic circuit oscillator inlet in fluid communication with the interaction region. A test spray can be performed to demonstrate that when pressurized fluid is introduced into the fluid channel, the pressurized fluid enters the chamber and interaction region and generates at least one oscillating flow vortex within the fluid channel's interaction region.

In the preferred embodiment of the assembly method, the fabricating step comprises molding the conformal fluidic circuit from a plastic material to provide a conformal, unitary, one-piece cup-shaped fluidic circuit member having the distal radial wall inner face features molded therein so that the cup-shaped member's inner surfaces provide an oscillation-inducing geometry which is molded directly into the cup's interior wall segments.

The above and still further objects, features and advantages of the present invention will become apparent upon consideration of the following detailed description of specific embodiments, particularly when taken in conjunction with the accompanying drawings, wherein like reference numerals in the various figures are utilized to designate like components.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. **1**A, is a cross sectional view in elevation of an aerosol sprayer with a typical valve actuator and swirl cup nozzle assembly, in accordance with the Prior Art.

FIG. **1**B, is a plan view of a standard swirl cup as used with aerosol sprayers and trigger sprayers, in accordance with the Prior Art.

FIG. **2** is a schematic diagram illustrating the typical actuator and nozzle assembly including the standard swirl cup of FIGS. **1**A and **1**B as used with aerosol sprayers, in accordance with the Prior Art.

FIGS. **3**A and **3**B are photographs illustrating the interior surfaces of a prototype fluidic cup oscillator showing the oscillation-inducing geometry or features of for the selected fluidic oscillator embodiment, in accordance with the present invention.

FIG. **4** is a cross-sectional diagram illustrating one embodiment of the fluidic cup's distal wall, interior fluidic geometry and exterior surface and power nozzle from the right side, in accordance with the present invention.

FIG. **5** is another cross-sectional diagram illustrating the embodiment of FIG. **4** from a viewpoint 90 degrees from the view of FIG. **4**, illustrating the fluidic cup's distal wall, interior fluidic geometry and exterior surface and power nozzle from above, in accordance with the present invention.

FIG. **6** is a schematic diagram illustrating the operational principals of an equivalent planar fluidic circuit having the flag mushroom configuration used to generate rectangular 3D sprays and showing the downstream location of the interaction region, between the first and second power nozzles, in accordance with the present invention.

FIG. **7**A illustrates a nozzle assembly in an actuator body having a bore with an uncovered distally projecting sealing post, in accordance with the present invention.

FIG. **7**B illustrates the actuator body and bore of FIG. **7**A with a fluidic cup installed over the distally projecting sealing post, in accordance with the present invention.

FIG. **8** is a diagram illustrating the operational principals of a second equivalent planar fluidic circuit having the mushroom configuration and showing the location of the interaction region between the first and second power nozzles and the downstream location of the throat or exit, in accordance with the present invention.

FIGS. **9**A and **9**B illustrate a prototype mushroom-equivalent fluidic cup embodiment, FIG. **9**A shows a front or distal perspective view illustrating the discharge orifice and the annular retention bead and FIG. **9**B shows installed partial cross section, illustrating the oscillating spray from the discharge orifice and the resilient engagement of the annular retention bead within the actuator's bore, in accordance with the present invention.

FIGS. **10**A-**10**D are diagrams illustrating a prototype fluidic cup mushroom-equivalent insert having a substantially circular discharge or exit lumen, and showing the two power nozzles and interaction region, in accordance with the present invention.

FIGS. **11**A-**11**D are diagrams illustrating a prototype fluidic cup assembly using the mushroom-equivalent insert of FIGS. **10**A-**10**D, in accordance with the present invention.

FIGS. **12**A-**12**E are diagrams illustrating a one-piece, unitary fluidic cup oscillator configured with integral fluidic oscillator inducing features molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen, and showing the two opposing venturi-shaped power nozzles aimed at the interaction region, in accordance with the present invention.

FIG. **13** is an exploded perspective view illustrating a hand-operated trigger sprayer configured for use with the one-piece, unitary fluidic cup oscillator of FIGS. **12**A-E or the fluidic cup assembly of FIGS. **9**A-**11**D, in accordance with the present invention.

FIG. **14** illustrates an alternative embodiment of the nozzle assembly configured as an aerosol actuator for use with a pressurized container having a distally projecting post with a distal end surface configured with a molded in-situ fluidic geometry and adapted to carry a fluidic nozzle component configured as a cylindrical cup having a substantially open proximal end and a substantially closed distal end wall with a centrally located power nozzle defined therein and covering the post, in accordance with the present invention.

FIG. **15** illustrates an alternative embodiment of the nozzle assembly configured as an trigger spray actuator having a distally projecting post with a distal end surface configured with a molded in-situ fluidic geometry and adapted to carry a fluidic nozzle component configured as a cylindrical cup having a substantially open proximal end and a substantially closed distal end wall with a centrally located power nozzle defined therein and covering the post, in accordance with the present invention.

FIG. **16** is a perspective view in elevation illustrating an alternative embodiment of the conformal, cup-shaped fluidic nozzle component configured as a cylindrical cup having a substantially open proximal end and a substantially closed distal end wall with a centrally located power nozzle defined therein and between first and second distally projecting alignment tabs or orientation ribs, in accordance with the present invention.

FIG. **17** is a side view in elevation illustrating the conformal, cup-shaped fluidic of FIG. **16** and showing the substantially closed distal end wall with the centrally located power nozzle defined therein and between the first and second distally projecting alignment tabs or orientation ribs, in accordance with the present invention.

FIG. **18** is a center plane cross section view in elevation illustrating the conformal, cup-shaped fluidic of FIGS. **16** & **17** and showing the substantially open proximal end and substantially closed distal end wall with the centrally located power nozzle defined therein and between the first and second distally projecting alignment tabs or orientation ribs, in accordance with the present invention.

FIGS. **19**A and **19**B are diagrams illustrating a one-piece, unitary filtered fluidic cup oscillator configured with integral proximally projecting filter post members arrayed around fluidic oscillator inducing features molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen, and showing the two opposing venturi-shaped power nozzles aimed at the interaction region, in accordance with the present invention.

FIGS. **20**A and **20**B are diagrams illustrating a one-piece, unitary filtered swirl cup nozzle member configured with integral proximally projecting filter post members arrayed around fluid swirl inducing features molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen, and showing the four swirl inducing nozzles aimed at a central discharge orifice, in accordance with the present invention.

FIGS. **21**A and **21**B are diagrams illustrating another one-piece, unitary filtered fluidic cup oscillator equipped nozzle member configured with integral proximally projecting filter post members arrayed around fluidic oscillator inducing features molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen, and showing the two opposing venturi-shaped power nozzles aimed at the interaction region, in accordance with the present invention

DESCRIPTION OF THE PREFERRED EMBODIMENT

FIGS. **1**A, **1**B and **2** show typical features of aerosol spray actuators and swirl cup nozzles used in the prior art, and these figures are described here to provide added background and context. Referring specifically to FIG. **1**A, a transportable, disposable propellant pressurized aerosol package **20** has container **26** enclosing a liquid product **50** and an actuator **40** which controls a valve mounted within a valve cup **24** which is affixed within the neck **28** of the container and supported by container flange **22**. Actuator **40** is depressed to open the valve and drive pressurized liquid through a spin-cup equipped nozzle **30** to produce an aerosol spray **60**. FIG. **1**B illustrates the inner workings of an actual spin cup **70** taken from a typical nozzle (e.g., **30**) where four lumens **72**, **74**, **76**, **78** are aimed to make four tangential flows enter a spinning chamber **80** where the continuously spinning liquid flows combine and emerge from the central discharge passage **80** as a substantially continuous spray of droplets of varying sizes (e.g., **60**), including the "fines" or miniscule droplets of fluid which many users find to be useless.

FIG. **2** is a schematic perspective diagram illustrating the typical actuator and nozzle assembly including the standard swirl cup of FIGS. **1**A and **1**B as used with aerosol sprayers, where the solid lines illustrate the outer surfaces of an actuator (e.g., **40**) and the phantom or dashed lines show hidden features including the interior surfaces of seal cup **70**. Presently, swirl cups (e.g., **70**) are fitted on to an actuator (e.g., **40**) and used with either manually pumped trigger sprayers or aerosol sprayer (e.g., **20**). It is a simple construction that does not require an insert and separate housing. The fluidic cup oscillator of the present invention builds upon this concept illustrated in FIGS. **1**A-**2**, but replaces the swirl cup's "spin" geometry with a fluidic geometry enabling fluidic sprays instead of a swirl spray. As noted above, swirl sprays are typically round, whereas fluidic sprays are characterized by planar, rectangular or square cross sections with consistent droplet size. Thus, the spray from a nozzle assembly made in accordance with the present invention can be adapted or customized for various applications and still retains the simple and economical construction characteristics of a "swirl" cup.

FIGS. **3**A-**13** illustrate structural features of exemplary embodiments of the conformal fluidic cup oscillator (e.g., **100**, **400**, **600** or **700**) of present invention and the method of assembling and using the components of the present invention. This invention describes and illustrates conformal, cup-shaped fluidic circuit geometries which emulate applicant's widely appreciated planar fluidic geometry configurations, but which have been engineered to generate the desired oscillating sprays from a conformal configuration such as a fluidic cup. Two exemplary planar fluidic oscillator configurations discussed here are: (1) the flag mushroom circuit (which, in its planar form, is illustrated in FIG. **6**) and (2) the mushroom circuit (which, in its planar form, is illustrated in FIG. **8**).

FIGS. **3**A-**5** illustrate the flag mushroom circuit equivalent embodiment, as converted in to a fluidic cup. Referring now to FIGS. **3**A and **3**B, a prototype fluidic oscillator **100** includes a two channel oscillation-inducing geometry **110** having fluid steering features and is configured as a substantially planar disk having an underside or proximal side **102** opposing a distal side **104** (see FIGS. **4** and **5**). The fluid oscillation-inducing geometry **110** is preferably molded into underside or proximal side **102**. In the illustrated embodiment, oscillation-inducing geometry **110** operates within a chamber with an interaction region **120** between a first power nozzle **122** and second power nozzle **124**, where first power nozzle **122** is configured to accelerate the movement of passing pressurized fluid flowing through the first nozzle to form a first jet of fluid flowing into the chamber's interaction region **120**, and the second power nozzle **124** is configured to accelerate the movement of passing pressurized fluid flowing through the second nozzle to form a second jet of fluid flowing into the chamber's interaction region **120**. The first and second jets collide and impinge upon one another at a selected inter-jet impingement angle (e.g., 180 degrees, meaning the jets impinge from opposite sides) and generate oscillating flow vortices within interaction region **120** which is in fluid communication with a discharge orifice or power nozzle **130** defined in the fluidic circuit's distal side surface **104**, and the oscillating flow vortices spray droplets through the discharge orifice as an oscillating spray of substantially uniform fluid droplets in a selected (e.g., rectangular) spray pattern having a selected spray width and a selected spray thickness.

FIG. **3**A illustrates the prototype fluidic oscillator **100** and shows the placement of a planar fluid sealing insert **180** covering part of the two channel oscillation-inducing geometry **110**, once affixed to proximal side **102**, to force fluid to flow into the wider portions or inlets of the first power nozzle **122** and second power nozzle **124**. The fluidic cup **100** and sealing insert **180** illustrated in FIGS. **3**A-**5** were molded from plastic materials but could be fabricated from any durable, resilient fluid impermeable material. As best seen in FIGS. **4** and **5**, prototype fluidic oscillator **100** is small and has an outer diameter of 5.638 mm and first power nozzle **122** and second power nozzle **124** are defined as grooves or troughs having a selected depth (e.g., 0.018 mm) with tapered sidewalls to provide a venturi-like effect. Discharge orifice or power nozzle **130** is an elongated slot-like aperture having flared or angled sidewalls, as best seen in FIGS. **4** and **5**.

In the fluidic cup embodiment **100** of FIGS. **3**A-**5**, applicants have effectively developed a replacement for the four channel swirl cup **70**, replacing it with a two-channel fluidic oscillator based on the operating principals of applicant's own planar flag mushroom circuit geometry. This results in a robust, easily variable rectangular spray pattern, with small droplet size. The fluidic circuit of FIGS. **3**A-**5** is capable of reliably achieving a generated spray fan angle ranging from 40° to 60° and a spray thickness ranging from 5° to 20°. These spray pattern performance measurements were taken at a flow rate range of 50-90 mLPM at 30 psi. The liquid product flow rate can be adjusted by varying the geometry's groove or trough depth "Pw", shown 0.18 mm in the embodiment of FIG. **4** & FIG. **5**. The spray's fan angle is controlled by the Upper Taper in throat or discharge **130**, shown as 75° in FIG. **4**. The spray thickness is controlled by the Lower Taper in the throat **130**, shown as 10° in FIG. **4**. The Upper Taper has been tested at values from 50° to 75°, and the Lower Taper has been tested at values from 0° to 20°. By adjusting these dimensions, fluidic cup **100** can be tailored to spray a wide range of liquid products in either aerosol (e.g., like FIG. **1**) or trigger spray (FIG. **13**) packages.

Turning now to FIG. **6**, equivalent planar fluidic circuit **200** has the flag mushroom configuration used to generate rectangular 3D sprays. In the planar form, the fluidic geometry is machined on a "flat chip", which is then inserted in to a rectangular housing slot (not shown) to seal the fluidic passages of geometry **210**. There are two power nozzles **222**, **224** shown by width "w", that are directly opposed to each other (180 degrees). There is also the interaction region cavity **220** shown at the impingement point. The output of fluidic circuit

200 is a rectangular 3D spray, whose fan and thickness is controlled by varying the floor taper angles of geometry **210**. In the new cup-shaped conformal oscillator geometry of the present invention, (e.g., shown in FIGS. **3**A-**5**), a functionally equivalent fluidic circuit is provided. In the new configuration, FIGS. **3**A-**5** shows the power nozzles **122**, **124**, which are comparable to **222** and **224** (see, truncated at the dashed line in FIG. **6**). The "front view" in FIG. **6**, is comparable to a "top view" in FIG. **3**. Thus, the power nozzle width shown by "w" in FIG. **6**, is comparable to the circuit feature in FIG. **3**, which, for example, is 0.18 mm (as shown in FIG. **5**). FIG. **4**, shows placement of sealing insert **180**, which is actually part of the actuator (e.g., actuator body or housing **340** as shown in FIG. **7**A) that seals the power nozzles, (e.g., as best seen in FIG. **7**A), with a feed area available for the power nozzles. This sealing insert **120** preferably presses against an actuator's sealing post **320** to define a volume that effectively functions much like the interaction region cavity **220** shown in FIG. **6**. The exhaust, throat or discharge port **230** of the planar fluidic circuit (e.g., **230**, the part below the dashed line in FIG. **6**) is comparable to discharge port **130** in FIGS. **4** and **5**.

Turning now to FIGS. **7**A and **7**B, actuator body or housing **340** includes a counter-sunk bore **330** with a distally projecting cylindrical sealing post **320** terminating distally in a substantially circular distal sealing surface. A fluidic cup **400** is preferably configured as a one-piece conformal fluidic oscillator and sealably engages sealing post **320** as shown in FIG. **7**B. Post **320** in actuator body or housing **340** serves to seal the fluidic circuit so that liquid product or fluid (e.g., like **50**) is emitted or sprayed only from discharge port **430** when the user chooses to spray or apply the liquid product. Fluidic cup **400** is essentially flag mushroom circuit equivalent having an output from discharge port **430** in the form of a rectangular 3D spray, and so the spray's fan angle and thickness are controlled by changing the taper angles just as for fluidic cup **100** as illustrated in FIG. **4**.

Another embodiment of the fluidic cup (mushroom cup **600**) has been developed to emulate the operating mechanics of the planar mushroom circuit **500** (shown in FIG. **8**). The flag mushroom cup **100** described above emits a spray comprised of a sheet oscillating in a plane normal to the centerline of the power nozzles **122**, **124**. The mushroom cup **600** (as best seen in FIGS. **9**A-B and FIGS. **11**A-**11**D) emits a single moving jet oscillating in space to form a flat fan spray **650** in plane with the power nozzles **622**, **624**. FIGS. **9**A and **9**B illustrate a mushroom-equivalent fluidic cup **600** (front or distal perspective view) having a cylindrical sidewall terminating distally in a closed distal end wall with a discharge orifice **630**. The fluidic cup's cylindrical side wall carries a radially projecting circumferential annular retention bead **694** and FIG. **9**B shows mushroom-equivalent fluidic cup **600** installed in actuator body **340**, within bore **330** (best seen in FIG. **7**A) in partial cross section, and illustrating the oscillating spray from discharge orifice **630** and the resilient engagement of the cup member's annular retention bead within actuator bore **330**. Referring now to FIG. **9**B, liquid product or fluid is shown flowing into fluidic cup and into the oscillator's power nozzles to generate the mushroom cup oscillator's spray fan **650** which has a selected fan angle **652** (e.g., 80 degrees) and remains in plane with the power nozzles **622**, **624** (best seen in FIGS. **10**A-**11**D). With the structure of fluidic cup **600**, the probability of the spray fan **650** rotating out of a permanently fixed plane relative to the power nozzles **622**, **624** is greatly reduced. From the liquid product vendor's perspective, this results in improved reliability. The mushroom cup **600** is also favorable from a manufacturing and injection molding standpoint. The exit orifice through which the fluid is exhausted from the interaction region **620** is a 0.3 mm-0.5 mm diameter through-hole or discharge orifice **630**, which can be formed with a simple pin, as an alternative to the complex and difficult to maintain tooling required to form the tapered slot **130** of the flag mushroom cup **100**.

Referring now to FIGS. **10**A-**10**D and **11**A-**11**D, the comparison between the planar mushroom fluidic oscillator **500** and mushroom cup oscillator **600** can be examined. The rectangular throat or exit **530** in planar oscillator **500** is reconfigured into a circular 0.25 mm exit or discharge port **630** as shown in FIGS. **10**A and **10**B. However, one may retain its original rectangular shape as well. The opposing power nozzles **522** and **524** and interaction region **520** are reconfigured as opposing power nozzles **622** and **624** and interaction region **620** in the disc shaped insert **680** for the cup-shaped fluidic **600** illustrated in FIGS. **10**A-**11**D.

FIGS. **10**A-**10**D and **11**A-**11**D illustrate fluidic cup oscillator **600** and shows the placement of molded disc-shaped insert **680** which includes the two channel oscillation-inducing geometry **610** and is carried within the substantially cylindrical cup member **690**, which has an open proximal end **692** and a flanged distal end including an inwardly projecting wall segment **694** having a circular distal opening **696**. Once disc-shaped insert **680** is affixed within cup member **690** abutting the flanged wall segment proximate the circular distal opening **696**, discharge port **630** is aimed distally. In operation, liquid product or fluid (e.g., **50**) introduced into fluidic cup oscillator **600** flow into the wider portions or inlets of the first power nozzle **622** and second power nozzle **624**. The fluidic insert disc **680** and cup member **690** are preferably injection molded from plastic materials but could be fabricated from any durable, resilient fluid impermeable material. As shown in FIGS. **10**A-**11**D, fluidic oscillator **600** is small and has an outer diameter of 4.765 mm and first power nozzle **622** and second power nozzle **624** are defined as grooves or troughs having a selected depth (e.g., 0.014 mm) with tapered sidewalls narrowing to 0.15 mm to provide a venturi-like effect. Discharge orifice or power nozzle **630** is a circular lumen or aperture having substantially straight pin-hole like sidewalls with a diameter of 0.25 mm, as best seen in FIG. **10**A.

Turning now to the embodiment illustrated in FIGS. **12**A-**12**E, the fluidic cup of the present invention is preferably configured as a one-piece injection-molded plastic fluidic cup-shaped conformal nozzle **700** and does not require a multi-component insert and housing assembly. The fluidic oscillator's operative features or geometry **710** are preferably molded directly into the cup's interior surfaces and the cup is configured for easy installation to an actuator body (e.g., **340**). This eliminates the need for multi-component fluidic cup assembly made from a fluidic circuit defining insert which is received within a cup-shaped member's cavity (as in the embodiments of FIGS. **9**A-**11**D). The fluidic cup embodiment **700** illustrated in FIGS. **12**A-**12**E provides a novel fluidic circuit which functions like a planar fluidic circuit but which has the fluidic circuit's oscillation inducing features and geometry **710** molded in-situ within a cup-shaped member so that one installed on an actuator's fluid impermeable, resilient support member (e.g., such as sealing post **320**) a complete and effective fluidic oscillator nozzle is provided.

Referring specifically to FIGS. **12**A-**12**E, a comparison between the planar fluidic oscillator described above and one-piece fluidic cup oscillator **700** can be appreciated. The circular (0.25 mm diameter) exit or discharge port **730** is proximal of interaction region **720**. The opposing tapered venturi-shaped power nozzles **722** and **724** and interaction region **720** molded in-situ within the interior surface of distal end-wall **780**. The molded interior surface of circular, planar or disc-shaped end wall **780** includes grooves or troughs defining the two channel oscillation-inducing geometry **710** and is carried within the substantially cylindrical sidewall segment **790**, which has an open proximal end **792** and a closed distal end including a distal surface having substantially centered circular distal port or throat **730** defined therethrough so that discharge port **730** is aimed distally. As best seen in FIGS. **12**C and **12**E, one-piece fluidic cup oscillator **700** is optionally configured with first and second parallel opposing substantially planar "wrench-flat" segments **792** defined in cylindrical sidewall segment **790**.

In operation, liquid product or fluid (e.g., **50**) introduced into one-piece fluidic cup oscillator **700** flows into the wider portions or inlets of the first power nozzle **722** and second power nozzle **724**. The one-piece fluidic cup oscillator **700** is preferably injection molded from plastic materials but could be fabricated from any durable, resilient fluid impermeable material. As shown in FIGS. **12**A-**12**E, one-piece fluidic cup oscillator **700** is small and has a small outer diameter (e.g., of 4.765 mm) and first power nozzle **722** and second power nozzle **724** are defined as grooves or troughs having a selected depth (e.g., 0.014 mm) with tapered sidewalls narrowing to 0.15 mm to provide the necessary venturi-like effect. Discharge orifice or power nozzle **630** is a circular lumen or aperture having substantially straight pin-hole like sidewalls with a diameter of approximately 0.25 mm, as best seen in FIGS. **12**A-**12**C.

One-piece fluidic cup oscillator **700** can be installed in an actuator like that shown in FIG. **7**B, as a replacement for mushroom-equivalent fluidic cup **600**, and the benefits of using one-piece fluidic cup oscillator **700** include: (1) no need to change tooling for the liquid product vendor, (2) no need to change the liquid product vendor's manufacturing line, (3) simpler to manage, and (4) the fluidic cup nozzle assemblies can be configured to provide application-optimized fluidic sprays for each of the liquid product vendor's product offerings. The conformal or cup-shaped fluidic oscillator structures and methods of the present invention can be used in various applications ranging from low flow rates (e.g., <50 ml/min at 40 psi, for pressurized aerosols (e.g., like FIG. **1**A, or with manual pump trigger sprays (e.g., **800**, as shown in FIG. **13**). The conformal fluidic geometry method can also be adapted for use with high flow rate applications (e.g. showerheads, which may be configured as a single fluidic cup that has one or multiple exits).

Persons having skill in the art will appreciate that modifications of the illustrated embodiments of the present invention can provide the similar benefits, for example, the interaction region **620** indicated in FIG. **10**A, can be circular (rather than rectangular). In such cases the oscillation mechanism is different than the mushroom circuit shown in FIG. **8**, and results in a three-dimensional spray rather than rectangular or planar sprays produced by examples shown in FIGS. **8**, **9**B and **10**A-**10**D. In such a case (with a circular interaction region), the fluidic cup can also be referred to as the 3D mushroom and will generate a 3D spray pattern of very uniform droplets. The conformal or fluidic cup oscillators illustrated herein (e.g., **100**, **400**, **600** or **700**) are readily configured to replace the prior art swirl cups in the traditional aerosol (or trigger sprayer) actuators. Advantages include a wide rectangular or planar spray pattern instead of a narrow non-uniform conical pattern. Fluidic oscillator generated droplets have a size that is generally much more consistent than for standard aerosol sprays while reducing unwanted fines and misting. The structures and methods of the present invention are adaptable to a variety of transportable or disposable cleaning products or devices e.g., carpet cleaners, shower room cleaners, paint sprayers and showerheads.

FIG. **13** is an exploded perspective view illustrating a hand-operated trigger sprayer **800** configured for use with any of these fluidic cup configurations (e.g., **100**, **400**, **600** or **700**). Preferably, trigger sprayer **800** is configured with the one-piece, unitary fluidic cup oscillator **700** of FIGS. **12**A-E or the fluidic cup assembly **600** of FIGS. **9**A-**11**D. The fluidic cup is useful with both hand-pumped trigger sprayers and propellant filled aerosol sprayers and can be configured to generate different sprays for different liquid or fluid products. Fluidic oscillator circuits are shown which can be configured to project a rectangular spray pattern (e.g., a 3D or rectangular oscillating pattern of uniform droplets **850**). The fluidic oscillator structure's fluid dynamic mechanism for generating the oscillation is conceptually similar to that shown and described in commonly owned U.S. Pat. Nos. 7,267,290 and 7,478,764 (Gopalan et al) which describe a planar mushroom fluidic circuit's operation; both of these commonly owned patents are incorporated herein in their entireties. The fluidic cup structure (e.g., **100**, **400**, **600** or **700**) has a fluid inlet defined within the cup's proximally projecting cylindrical sidewall (see FIG. **9**B), and the exemplary fluid inlet is annular and of constant cross section, but the fluidic cup's fluid inlet can also be tapered or include step discontinuities to enhance pressurized fluid instability.

It will be appreciated that the novel fluidic circuit of the present invention (e.g., **100**, **400**, **600** or **700**) is adapted for many conformal configurations. There are several consumer applications such as aerosol sprayers or trigger sprayers (e.g., **800**) where it is desirable to customize sprays. Fluidic sprays are very useful in these cases but adapting typical commercial aerosol sprayers and trigger sprayers to accept the standard fluidic oscillator configurations would cause unreasonable product manufacturing process changes to current aerosol sprayers and trigger sprayers thus making them much more expensive.

A nozzle assembly or spray head including a lumen or duct for dispensing or spraying a pressurized liquid product or fluid from a valve, pump or actuator assembly (e.g., **340** or **840**) draws from a disposable or transportable container to generate an oscillating spray of very uniform fluid droplets. The fluidic cup nozzle assembly includes an actuator body (e.g., **340** or **840**) having a distally projecting sealing post (e.g., **320** or **820**) having a post peripheral wall terminating at a distal or outer face, and the actuator body includes a fluid passage communicating with the lumen.

Cup-shaped fluidic circuit (e.g., **100**, **400**, **600** or **700**) is mounted in the actuator body member having a peripheral wall extending proximally into a bore (e.g., **330** or **830**) in the actuator body radially outwardly of the sealing post (e.g., **320** or **820**) and having a distal radial wall comprising an inner face opposing the sealing post's distal or outer face to define a fluid channel including a chamber having an interaction region between the body's sealing post (e.g., **320** or **820**) and said cup-shaped fluidic circuit's peripheral wall and distal wall; the chamber is in fluid communication with the actuator body's fluid passage to define a fluidic circuit oscillator inlet so the pressurized fluid can enter the fluid channel's chamber and interaction region (e.g., **120**, **620** or **720**). The cup-shaped fluidic circuit distal wall's inner face carries the fluidic geometry (e.g., **110**, **610** or **710**), so it is configured to define within the chamber a first power nozzle and second power nozzle, where the first power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the first nozzle to form a first jet of fluid flowing into the chamber's interaction region (e.g., **120**, **620** or **720**), and the second power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the second nozzle to form a second jet of fluid flowing into the chamber's interaction region (e.g., **120**, **620** or **720**). The first and second jets impinge upon one another at a selected inter-jet impingement angle (e.g., 180 degrees, meaning the jets impinge from opposite sides) and generate oscillating flow vortices within the fluid channel's interaction region (e.g., **120**, **620** or **720**) which is in fluid communication with a discharge orifice or power nozzle (e.g., **130**, **630** or **730**) defined in the fluidic cup's distal wall, and the oscillating flow vortices spray droplets through the discharge orifice (e.g., **130**, **630** or **730**) as an oscillating spray of substantially uniform fluid droplets in a selected (e.g., rectangular) spray pattern having a selected spray width and a selected spray thickness, as shown in FIGS. **9**B and **13**).

The first and second power nozzles are preferably venturi-shaped or tapered channels or grooves in the cup-shaped fluidic circuit distal wall's inner face and terminate in a rectangular or box-shaped interaction region (e.g., **120**, **620** or **720**) carried by or defined in the cup-shaped fluidic circuit distal wall's inner face. The interaction region could also be cylindrical, which affects the spray pattern.

The cup-shaped fluidic circuit's power nozzles, interaction region and throat can be defined in a disk or pancake shaped insert fitted within the cup (e.g., **100** **400** or **600**), but are preferably molded directly into interior wall segments in situ to provide one-piece fluidic cup oscillator **700**. When molded from plastic as a one-piece cup-shaped fluidic circuit **700**, the fluidic cup is easily and economically fitted onto the actuator's sealing post (e.g., **320**), which typically has a distal or outer face that is substantially flat and fluid impermeable and in flat face sealing engagement with the cup-shaped fluidic circuit distal wall's inner face. The sealing post's peripheral wall and the cup-shaped fluidic circuit's peripheral wall (e.g., **690** or **790**) are spaced axially to define an annular fluid channel and (as shown in FIG. **9**B) the peripheral walls are generally parallel with each other but may be tapered to aid in developing greater fluid velocity and instability.

As a fluidic circuit item for sale or shipment to others, the conformal, unitary, one-piece fluidic circuit **700** is configured for easy and economical incorporation into a nozzle assembly or aerosol spray head actuator body including distally projecting sealing post (e.g., **320**) and a lumen for dispensing or spraying a pressurized liquid product or fluid from a disposable or transportable container to generate an oscillating spray of fluid droplets. The fluidic cup (e.g., **100**, **400**, **600** or **700**) includes a cup-shaped fluidic circuit member having a peripheral wall extending proximally and having a distal radial wall comprising an inner face with fluid constraining operative features or a fluidic geometry (e.g., **110**, **610** or **710**) defined therein and an open proximal end (e.g., **692** or **792**) configured to receive an actuator's sealing post (e.g., **320**). The cup-shaped member's peripheral wall and distal radial wall have inner surfaces comprising a fluid channel including a chamber when the cup-shaped member is fitted to the actuator body's sealing post and the chamber is configured to define a fluidic circuit oscillator inlet in fluid communication with an interaction region so when the cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced, (e.g., by pressing the aerosol spray button and releasing the propellant), the pressurized fluid can enter the fluid channel's chamber and interaction region and generate at least one oscillating flow vortex within the fluid channel's interaction region (e.g., **120**, **620** or **720**).

The cup shaped member's distal wall includes a discharge orifice (e.g., **130**, **630** or **730**) in fluid communication with the chamber's interaction region, and the chamber is configured so that when the cup-shaped member (e.g., **100**, **400**, **600** or **700**) is fitted to the body's sealing post and pressurized fluid is introduced via the actuator body, the chamber's fluidic oscillator inlet is in fluid communication with a first power nozzle and second power nozzle, and the first power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the first nozzle to form a first jet of fluid flowing into the chamber's interaction region, and the second power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through the second nozzle to form a second jet of fluid flowing into the chamber's interaction region, and the first and second jets impinge upon one another at a selected inter-jet impingement angle and generate oscillating flow vortices within fluid channel's interaction region. As before, the chamber's interaction region (e.g., **120**, **620** or **720**) is in fluid communication with the discharge orifice (e.g., **130**, **630** or **730**) carried by or defined in said fluidic circuit's distal wall, and the oscillating flow vortices spray from the discharge orifice as an oscillating spray of substantially uniform fluid droplets in a selected spray pattern having a selected spray width and a selected spray thickness.

In the method of the present invention, liquid product manufacturers making or assembling a transportable or disposable pressurized package for spraying or dispensing a liquid product, material or fluid would first obtain or fabricate the conformal fluidic cup circuit (e.g., **100**, **400**, **600** or **700**) for incorporation into a nozzle assembly or aerosol spray head actuator body which typically includes the standard distally projecting sealing post (e.g., **320**). The actuator body has a lumen for dispensing or spraying a pressurized liquid product or fluid from the disposable or transportable container to generate a spray of fluid droplets, and the conformal fluidic circuit includes the cup-shaped fluidic circuit member having a peripheral wall extending proximally and having a distal radial wall comprising an inner face with features defined therein and an open proximal end configured to receive the actuator's sealing post. The cup-shaped member's peripheral wall and distal radial wall have inner surfaces comprising a fluid channel including a chamber with a fluidic circuit oscillator inlet in fluid communication with an interaction region; and the cup shaped member's peripheral wall preferably has an exterior surface carrying a transversely projecting snap-in locking flange.

In the preferred embodiment of the assembly method, the product manufacturer or assembler next provides or obtains an actuator body (e.g., **340**) with the distally projecting sealing post centered within a body segment having a snap-fit groove configured to resiliently receive and retain the cup shaped member's transversely projecting locking flange (e.g., **694** or **794**). The next step is inserting the sealing post into the cup-shaped member's open distal end (e.g., **692** or **792**) and engaging the transversely projecting locking flange into the actuator body's snap fit groove to enclose and seal the fluid channel with the chamber and the fluidic circuit oscillator inlet in fluid communication with the interaction region (e.g., **120**, **620** or **720**). A test spray can be performed to demonstrate that when pressurized fluid is introduced into the fluid channel, the pressurized fluid enters the chamber and interaction region and generates at least one oscillating flow vortex within the fluid channel's interaction region.

In the preferred embodiment of the assembly method, the fabricating step comprises molding the conformal fluidic circuit from a plastic material to provide a conformal, unitary, one-piece cup-shaped fluidic circuit member **700** having the distal radial wall inner face features or geometry **710** molded therein so that the cup-shaped member's inner surfaces provide an oscillation-inducing geometry which is molded directly into the cup's interior wall segments.

It will be appreciated that the conformal fluidic cup (e.g., **100**, **400**, **600** or **700**) and method of the present invention readily conforms to the industry-standard actuator stem used in typical aerosol sprayers and trigger sprayers and so replaces the prior art "swirl cup" that goes over the actuator stem (e.g., **320**), and the benefits of using a fluidic oscillator (e.g., **100**, **400**, **600** or **700**) are made available with little or no significant changes to other parts of the industry standard liquid product packaging. With the fluidic cup and method of the present invention, vendors of liquid products and fluids sold in commercial aerosol sprayers and trigger sprayers can now provide very specifically tailored or customized sprays.

The term "conformal" as used here, means that the fluidic oscillator is engineered to engage and "conform" to the exterior configuration of the dispensing package or applicator, where the conformal fluidic circuit (e.g., **100**, **400**, **600** or **700**) has an "interior" and an "exterior" with a throat or discharge lumen (e.g., **130**, **630** or **730**) in fluid communication between the two, and where the conformal fluidic's interior surface carries or has defined therein a fluidic oscillator geometry (e.g., **110**, **610** or **710**) which operates on fluid passing therethrough to generate an oscillating spray of fluid droplets having a controlled, selected size, where the spray has a selected rectangular or 3D pattern (e.g., **850**, as best seen in FIG. **13**).

Turning now to the nozzle assembly embodiment illustrated in FIG. **14**, nozzle assembly **900** is configured as an aerosol actuator for use with a pressurized container adapted to spray a fluid product such as sun screen in a selected spray pattern. Nozzle assembly **900** has a transversely aligned, distally projecting post **902** with a distal end surface **904** configured with a molded in-situ fluidic geometry **920**, **922**, **924** defined therein. Fluidic post **902** projects transversely within annular bore **330** and is adapted to sealably engage and carry a fluidic nozzle component configured as a cylindrical cup **990** having a substantially open proximal end and a substantially closed distal end wall with a centrally located power nozzle **930** defined therein and covering the post **902**. Functionally, nozzle assembly **900** is similar to the nozzle assembly embodiments described above and in FIGS. **9A-12**, where a fluidic cup (e.g., **700**) seals against a "blank" post **320**. Nozzle assembly **900** differs from those embodiments because distal end surface **904** has conformal fluidic geometry molded therein, and that fluidic geometry includes a substantially rectangular central interaction chamber **920** which is in fluid communication with a first venturi-shaped power nozzle **922** which passes pressurized fluid product from annular lumen **330** into interaction chamber **920** along a first power nozzle axis. Interaction chamber **920** is also in fluid communication with a second venturi-shaped power nozzle **924** which passes pressurized fluid product from annular lumen **330** into interaction chamber **920** along second power nozzle axis which is preferably aligned with the axis of first power nozzle **922**, to create colliding flows of pressurized fluid in interaction chamber **920**. The first and second power nozzles **922**, **924** are preferably venturi-shaped or tapered channels or grooves in the post's distal end surface **904** (as shown), but may also be configured as straight-walled lumens configured to pass pressurized fluid product from annular lumen **330** into interaction chamber **920** along axes which intersect in interaction chamber **920**. Conformal fluidic circuit **900** provides a selected inter-jet impingement angle of 180 degrees and chamber **920** is configured so that when said cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via said actuator body, oscillating flow vortices are generated within interaction chamber **920** by opposing jets of fluid first and second power nozzles **922**, **924**.

Nozzle assembly **900** may also be configured to emulate the operating mechanics of the planar mushroom circuit **500** (shown in FIG. **8**). The fluidic post nozzle assembly **900** is configurable to emit a spray comprised of a sheet oscillating in a plane normal to the centerline of the power nozzles **922**, **924** or emit a single moving jet oscillating in space to form a flat fan spray (e.g., like spray **650**) in plane with the power nozzles **922**, **924**. Cup member **990** has a cylindrical sidewall terminating distally in a closed distal end wall with discharge orifice **930** and the cylindrical side wall carries a radially projecting circumferential annular retention bead **994** which is snap fit into sealing engagement with the actuator body within bore **330** to provide resilient engagement of the cup member's annular retention bead **994** within actuator bore **330**. The mushroom cup exit orifice through which the fluid is exhausted from the interaction region **920** is preferably a 0.3 mm-0.5 mm diameter through-hole or discharge orifice **930**, which can be formed with a simple pin, as above.

FIG. **15** illustrates another nozzle assembly **1000** configured as a trigger spray actuator having a transversely aligned, distally projecting post **1002** with a distal end surface **1004** configured with a molded in-situ fluidic geometry **1020**, **1022**, **1024** defined therein. Fluidic post **1002** projects transversely from the spray actuator body and is adapted to sealably engage and carry a fluidic nozzle component configured as a cylindrical cup or cap **1090** having a substantially open proximal end and a substantially closed distal end wall with a centrally located power nozzle **1030** defined therein and covering the post **1002**. Functionally, nozzle assembly **1000** is similar to the nozzle assembly embodiments described above and in FIG. **13**, where a fluidic cup (e.g., **700**) seals against a "blank" post **820**. Nozzle assembly **1000** differs from the embodiment of FIG. **13** because distal end surface **1004** has conformal fluidic geometry molded therein, and that fluidic geometry includes a substantially rectangular central interaction chamber **1020** which is in fluid communication with a first venturi-shaped power nozzle **1022** which passes pressurized fluid product from annular lumen **830** into interaction chamber **1020** along a first power nozzle axis. Interaction chamber **1020** is also in fluid communication with a second venturi-shaped power nozzle **1024** which passes pressurized fluid product from annular lumen **830** into interaction chamber **1020** along second power nozzle axis which is preferably aligned with the axis of first power nozzle **1022**, to create colliding flows of pressurized fluid in interaction chamber **1020**. The first and second Power nozzles **1022**, **1024** are preferably venturi-shaped or tapered channels or grooves in the post's distal end surface **1004** (as shown), but may also be configured as straight-walled lumens configured to pass pressurized fluid product from annular lumen **830** into interaction chamber **1020** along axes which intersect in interaction chamber **1020**. Conformal fluidic circuit **1000** also provides a selected inter-jet impingement angle of 180 degrees and chamber **1020** is configured so that when said cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via said actuator body, oscillating flow vortices are generated within interaction chamber **1020** by opposing jets of fluid first and second power nozzles **1022**, **1024**.

Nozzle assembly **1000** may also be configured to emulate the operating mechanics of the planar mushroom circuit **500** (shown in FIG. **8**). The fluidic post nozzle assembly **1000** is configurable to emit a spray comprised of a sheet oscillating in a plane normal to the centerline of the power nozzles **1022**, **1024** or emit a single moving jet oscillating in space to form a flat fan spray (e.g., like spray **650**) in plane with the power nozzles **1022**, **1024**. The exit orifice **1030** through which the fluid is exhausted from the interaction region **1020** is preferably a 0.3 mm-0.5 mm diameter through-hole or discharge orifice **1030**, which can be formed with a simple pin, as above.

Turning now to the embodiments illustrated in FIGS. **16-18**, an alternative embodiment of the conformal, fluidic cup **1100** is configured as a substantially cylindrical unitary, one piece cup-shaped component having a substantially open proximal end and a substantially closed distal end wall **1180** with a centrally located power nozzle **1130** defined therein and between spaced apart, parallel first and second distally projecting alignment tabs or wall segments.

FIG. **16** is a perspective view in elevation illustrating an alternative embodiment of the conformal, cup-shaped fluidic nozzle component **1100** and FIG. **17** is a side view in elevation showing the closed distal end wall **1180** with the centrally located power nozzle **1130** defined therein and between the first and second distally projecting alignment tabs or orientation ribs **1150**, **1152**. FIG. **18** is a center plane cross section view of the conformal, cup-shaped fluidic cup **1100** showing the substantially open proximal end and substantially closed distal end wall **1180** with the centrally located power nozzle **1130** defined between the first distally projecting orientation rib **1150** and second distally projecting orientation rib **1152**.

Ribbed conformal fluidic cup **1100** is preferably configured as a one-piece injection-molded plastic fluidic cup-shaped conformal nozzle component and does not require a multi-component insert and housing assembly. The fluidic oscillator's operative features or geometry **1110** are preferably molded directly into the cup's interior surfaces and the cup is configured for easy installation to an actuator body (e.g., **340**). This eliminates the need for multi-component fluidic cup assembly made from a fluidic circuit defining insert which is received within a cup-shaped member's cavity (as in the embodiments of FIGS. **9**A-**11**D). The fluidic cup embodiment **1100** illustrated in FIGS. **16-18** provides a novel fluidic circuit which functions like a planar fluidic circuit but which has the fluidic circuit's oscillation inducing features and geometry **110** molded in-situ within a cup-shaped member so that one installed on an actuator's fluid impermeable, resilient support member (e.g., such as sealing post **320**) a complete and effective fluidic oscillator nozzle is provided.

A comparison between the planar fluidic oscillator described above and one-piece fluidic cup oscillator **1100** is useful to illustrate operating principles. The circular (0.25 mm diameter) exit or discharge port **1130** is proximal of interaction region **1120**. The interaction region **1120** and opposing tapered venturi-shaped power nozzles resemble those of fluidic cup **700** (i.e., **720**, **722** and **724** as seen in FIGS. **12**A and **12**C) and are molded in-situ within the interior surface of distal end-wall **1180**. The molded interior surface of circular, planar or disc-shaped end wall **1180** includes grooves or troughs defining the two channel oscillation-inducing geometry **1110** and is carried within the substantially cylindrical sidewall segment **1190**, which has an open proximal end **1192** opposing closed distal end including a distal surface having distal port or throat **1130** defined therethrough so that discharge port **1130** is aimed distally. As best seen in FIGS. **12**C and **12**E, one-piece fluidic cup oscillator **700** is optionally configured with an annular ring projection **1194** carried on cylindrical sidewall **1190**.

In operation, liquid product or fluid (e.g., **50**) is introduced into one-piece fluidic cup oscillator **1100** and flows into the wider portions or inlets of the first power nozzle and second power nozzle to collide within the interaction chamber of conformal fluidic **1110**. The one-piece fluidic cup oscillator **1100** is preferably injection molded from plastic materials but could be fabricated from any durable, resilient fluid impermeable material. One-piece fluidic cup oscillator **1100** is small and has a small outer diameter (e.g., of 4.765 mm) and the features of fluidic geometry **1110** are defined as grooves or troughs having a selected depth (e.g., 0.014 mm) with tapered sidewalls narrowing to 0.15 mm to provide the necessary venturi-like effect. Discharge orifice or power nozzle **1130** is a circular lumen or aperture having substantially straight pin-hole like sidewalls with a diameter of approximately 0.25 mm.

One-piece ribbed fluidic cup **1100** can be installed in an actuator like that shown in FIG. **7**B, as a replacement for mushroom-equivalent fluidic cup **600**, and the benefits of using one-piece fluidic cup oscillator **1100** include: (1) no need to change tooling for the liquid product vendor, (2) no need to change the liquid product vendor's manufacturing line, (3) simpler to manage, and (4) the fluidic cup nozzle assemblies can be configured to provide application-optimized fluidic sprays for each of the liquid product vendor's product offerings. The conformal or cup-shaped fluidic oscillator structures and methods of the present invention can be used in various applications ranging from low flow rates (e.g., <50 ml/min at 40 psi, for pressurized aerosols (e.g., like FIG. **1**A, or with manual pump trigger sprays (e.g., **800**, as shown in FIG. **13**). The conformal fluidic geometry method can also be adapted for use with high flow rate applications (e.g. showerheads, which may be configured as a single fluidic cup that has one or multiple exits).

It will be appreciated that the ribbed fluidic cup embodiment of FIGS. **16-18** will be advantageous for use in aerosol can & trigger spray applications, where it is desirable to efficiently apply a uniform coat of fluid product onto a surface. A rectangular spray pattern (e.g., **850**) is favorable to a circular or conical spray pattern in this regard. Additionally, it is favorable for the nozzle to form droplets large enough they do not bounce off the target surface (e.g., having droplet Volume Median Diameter or VMD>0.10 mm). Therefore, the nozzle assembly of the present invention is able to apply a uniform coat of fluid onto a surface with greater efficiency than a standard swirl nozzle cup. For purposes of nomenclature, VMD is a value where 50% of the total volume of liquid sprayed is made up of drops with diameters larger than the median value and 50% smaller than the median value. In accordance with the present invention, droplet size is a function of pressure, viscosity, & power nozzle area. Applicants have observed a correlation between droplet size and fluid flow rate. That is, for a given fluid, nozzle assemblies having lower flow cups produce smaller droplets than nozzle assemblies having higher flow cups. Flow rate is controlled by the size of the power nozzle area "PA" where Pw*Pd=PA. For the embodiment of FIGS. **14-18**, Pw=0.100-0.150 mm; Pd=0.150-0.200 mm. Droplet size is also affected by fluid characteristics. Fluid characteristics vary with the Product, and using sun screen as an example, the fluid characteristics vary by product line & SPF. In sunscreen products, a typical solvent is denatured alcohol, which has a typical density of 789 kg/m3. The proportion of denatured alcohol in the products of interest ranges from 53.2% to 81.6%. As SPF increases, the proportion or percentage of denatured alcohol in the product decreases, and as a result viscosity & droplet size increase. As SPF increases, VMD typically varies in the range from 0.12 to 0.35 mm (for a full and completely pressurized new can). In aerosol packages of interest, the fluid product is sprayed via bag on valve aerosol assembly with no intermixed propellants. As a result, the nozzle pressure decreases from 120 psi to 40 psi as the product is dispensed and the can is emptied. As pressure decreases, droplet size increases.

For a desired spray which is rectangular (e.g., **850**), the spray pattern must be oriented so that the consumer obtains a satisfactory result when spraying the product, and spray orientation is a function of nozzle assembly. A rectangle naturally comprises a major & minor axis, it is desirable to orient the spray pattern (e.g. **850**) relative to the actuator, housing, aerosol can, or trigger sprayer. Desired orientation of spray is typically horizontal or vertical. When assembling the fluidic cup **1100** in a large scale mass production environment, an external feature is required to index and assemble the cup **1100** a desired angular orientation relative to the actuator (e.g., **340**) the cup is being inserted into. Alignment features tested include parallel flat surfaces on either side of the otherwise round side walls of the cup (e.g., as shown in FIGS. **12**C and **12**D), a groove in the front face of the cup, and the preferred embodiment, the pair of ribs **1150**, **1152** protruding downstream from the front face **1180** of the cup **1100**. The ribs **1150**, **1152** are placed on top and bottom of the plane established by the fan angle of the spray. Ribs **1150**, **1152** have drafted walls and are spaced apart at adequate distance (e.g., 1 mm) from the centerline of discharge orifice **1130** to avoid contact with the spray.

In the illustrated embodiment, the cup-shaped fluidic nozzle component's alignment tabs **1150**, **1152** are configured to engage an installation socket or end effector which configured to couple with and support the cup-shaped member **1100**. The preferred embodiment illustrated in FIGS. **16-18** provided the most reliable feature for bowl fed robotic high speed assembly equipment to index and assemble a complete nozzle assembly with fluidic cup **1100**, while not disturbing the spray after passing through the exit hole **1130**. The spaced, parallel distally projecting wall segments are spaced apart about the power nozzle opening and the inter-wall spacing (e.g., approximately 22.14 mm) and wall height (or distal projection length, approx. 0.75 mm) are selected with the Rib Draft Angle (1 degree) to avoid interfering with the desired spray's edges. For the embodiment illustrated in FIGS. **17** and **18**, the plane of the spray's fan angle is perpendicular to the page. These dimensions are critical to reliably manufacture the ribs and to avoid the spray attaching to the ribs. Product fluid spray attachment to ribs or alignment tabs **1150**, **1152** is undesirable because the fluid begins to entrain air, and droplet size is increased.

In the illustrated embodiment, the cup-shaped fluidic nozzle component's alignment tabs **1150**, **1152** provide rotational alignment features which can be engaged with an installation socket or end effector configured to couple with, support and rotate the cup-shaped member **1100**. Alternative configurations of distal wall features could be defined in or around the distal end wall's outer or distal surface to work with a cooperating end effector or tool. For example, a plurality of blind bores or holes (not shown) could be defined within the cup's distal wall surface and configured to receive a spanner end effector with first and second pin members dimensioned to be received within said cup's distal blind bores or holes. Alternatively, the central region of said cup's distal wall could project distally to define a central distal projection (not shown) so that power nozzle **1130** is defined in the central distal projection, and an end effector configured to receive the cup's central distal projection would then be provided for alignment and installation of the cup member on the nozzle's sealing post.

The end effector (not shown) is configured to align the cup **1100** by rotating it before or after placement over the sealing post by rotating the cup about the cup's central axis which is co-axial with the sealing post's central axis, to provide a selected angular orientation for the cup and the resulting spray (e.g., **650** or **850**).

In use, the conformal, cup-shaped fluidic nozzle component's alignment tabs **1150**, **1152** are engaged with an installation socket or end effector which configured to engage, support and orient or rotate said cup-shaped member on the nozzle assembly's sealing post. The end effector is configured to automatically align the cup by rotating it before or after placement over the sealing post by rotating the cup about the cup's central axis which is co-axial with the sealing post's central axis, to provide a selected angular orientation (e.g., vertical, with the spray's major axis aligned vertically and parallel to the product packages major axis) for the cup and the resulting spray.

In the preferred embodiment of the assembly method, the product manufacturer or assembler provides or obtains an actuator body (e.g., **340**) with the distally projecting sealing post centered within a body segment having a snap-fit groove configured to resiliently receive and retain the cup shaped member's transversely projecting locking flange **1194**. The cup **1100** is engaged within an end effector (not shown) and automatically aligned using the conformal, cup-shaped fluidic nozzle component's alignment tabs or orientation ribs **1150**, **1152** are supported and oriented or rotated to align cup **1100** on the nozzle assembly's sealing post. The end effector is configured to automatically align the cup by rotating it before or after placement over the sealing post by rotating the cup about the cup's central axis which is co-axial with the sealing post's central axis, to provide a selected angular orientation (e.g., vertical, with the spray's major axis aligned vertically and parallel to the product packages major axis) for the cup and the resulting spray. The next step is inserting the sealing post into the cup-shaped member's open distal end **1192** and engaging the transversely projecting locking flange **1192** into the actuator body's snap fit groove to enclose and seal the fluid channel with the chamber and the fluidic circuit oscillator inlet in fluid communication with the fluidic's interaction chamber **1110**. A test spray can be performed to demonstrate that when pressurized fluid is introduced into the nozzle assembly, the pressurized fluid enters the fluidic's interaction chamber **1110** and generates at least one oscillating flow vortex which is aligned to provide a desired spray (e.g., **650** or **850**).

Turning now to the "filter cup" embodiments of FIGS. **19**A-**21**B, FIGS. **19**A and **19**B are diagrams illustrating a one-piece, unitary filtered fluidic cup oscillator nozzle member **1200** configured with a plurality of (e.g., twelve) integral proximally projecting filter post members (**1240**A-**1240**L) which are spaced apart and arrayed around fluidic oscillator inducing features **1220**, **1222**, **1224** molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen **1230**, where the two opposing venturi-shaped power nozzles **1222**, **1224** are aimed at the interaction region **1220**. The spaced proximally projecting filter post members (**1240**A-**1240**L) define a filtering region with lumens or filter openings **1250** therebetween so that pressurized fluid flowing into the nozzle assembly flows between the filter post members via inter-post filtering lumens **1250** and into a ring shaped volume **1252** which is in fluid communication with fluid oscillation inducing features **1220**, **1222**, **1224** and discharge orifice **1230** so that filtered fluid flows and the nozzle sprays without adverse effects caused by fluid product clogs.

Filtered fluidic cup 1200 is preferably configured as a one-piece injection-molded plastic fluidic cup-shaped conformal nozzle and does not require a multi-component insert and housing assembly. The fluidic oscillator's operative features or geometry 1210 are preferably molded directly into the cup's interior surfaces and the cup is configured for easy installation to an actuator body (e.g., 340). This eliminates the need for multi-component fluidic cup assembly made from a fluidic circuit defining insert which is received within a cup-shaped member's cavity (as in the embodiments of FIGS. 9A-11D). The filtered fluidic cup embodiment illustrated in FIGS. 19A and 19B provide a novel filtered fluidic circuit which functions like a planar fluidic circuit but which has the fluidic circuit's oscillation inducing features and geometry 1210 molded in-situ within a cup-shaped member so that once installed on an actuator's fluid impermeable, resilient support member (e.g., such as sealing post 320) a sealed conduit is created and a complete and effective fluidic oscillator nozzle is provided. The circular (0.25 mm diameter) exit or discharge port 1230 is in fluid communication and receives fluid from interaction region 1220. The opposing tapered venturi-shaped power nozzles 1222 and 1224 and interaction region 1220 are preferably molded in-situ within the interior surface of distal end-wall 1280. The molded interior surface of circular, planar or disc-shaped end wall 1280 includes grooves or troughs defining the two channel oscillation-inducing geometry 1210 and is carried within the substantially cylindrical sidewall segment 1290, which has an open proximal end 1292 and a closed distal end including a distal surface having substantially centered circular distal port or throat 1230 defined therethrough so that discharge port 1230 is aimed distally. One-piece filtered fluidic nozzle member 1200 is optionally configured with first and second parallel opposing substantially planar "wrench-flat" segments (not shown) defined in cylindrical sidewall segment 1290.

It will be appreciated by those with skill in the art that filtered fluidic cup member 1200 includes a new filtering feature integrally molded within the fluidic cup structure. This filtering feature can be configured as a ring of inwardly and proximally projecting filter posts that force liquid product through interstitial filter openings 1250 and filter out coagulated or congealed product, larger particles etc. ("solids") and prevent those solids from clogging the fluidic channels. The cup configuration defines an inner ring-shaped volume which receives the filtered liquid and feeds the fluidic channels. Thus multiple filter openings 1250 are available and liquid product flow will not be interrupted even if some of the filter openings become temporarily clogged. In the example illustrated FIGS. 19A and 19B twelve radially arrayed and equal area filter openings are defined between the filter post members and so even with a few openings clogged, the others remain available and in continuous fluid communication with the discharge orifice 1230.

Turning now to FIGS. 20A and 20B, a one-piece, unitary filtered swirl cup nozzle member 1300 is configured with integral proximally projecting filter post members arrayed around fluid swirl inducing features molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen, where a plurality (e.g. four) swirl inducing nozzles 1372, 1374, 1376, 1378 are in fluid communication with and aim filtered, pressurized at central discharge orifice 1380. The spaced proximally projecting filter post members (1340A-1340L) define a filtering region with lumens or filter openings 1350 therebetween so that pressurized fluid flowing into the nozzle assembly flows between the filter post members via inter-post filtering lumens 1350 and into a ring shaped volume 1352 which is in fluid communication with fluid swirl inducing features 1372, 1374, 1376, 1378 and discharge orifice 1330 so that filtered fluid flows and the nozzle sprays without adverse effects caused by fluid product clogs.

Filtered swirl cup 1300 is preferably configured as a one-piece injection-molded plastic fluidic cup-shaped conformal nozzle and does not require a multi-component insert and housing assembly. The filtered swirl cup's operative features or geometry 1310 are preferably molded directly into the cup's interior surfaces and the cup is configured for easy installation to an actuator body (e.g., 340). This eliminates the need for multi-component filter and swirl cup assembly made from inserts received within a cup-shaped member's cavity. The filtered swirl cup embodiment illustrated in FIGS. 20A and 20B provide a novel filtered swirl cup nozzle which has the filtering structural features (1340A-1340L) and the swirl inducing geometry 1310 molded in-situ within a cup-shaped member so that once installed on an actuator's fluid impermeable, resilient support member (e.g., such as sealing post 320) a sealed conduit is created and a complete and effective filtered fluid spraying nozzle is provided. The circular (0.25 mm diameter) exit or discharge port 1330 is in fluid communication and receives fluid from the swirl channels 1372, 1374, 1376, 1378 and filter posts 1340A-1340L are preferably molded in-situ within the interior surface of distal end-wall 1380. The molded interior surface of circular, planar or disc-shaped end wall 1380 includes grooves or troughs defining the swirl-inducing geometry 1310 and is carried within the substantially cylindrical sidewall segment 1390, which has an open proximal end 1392 and a closed distal end including the distal surface having substantially centered circular distal port or throat 1380 defined therethrough so that discharge port 1380 is aimed distally. One-piece filtered swirl cup nozzle member 1300 is optionally configured with first and second parallel opposing substantially planar "wrench-flat" segments (not shown) defined in cylindrical sidewall segment 1390.

It will be appreciated by those with skill in the art that filtered swirl cup member 1300 includes a new filtering feature integrally molded within the fluidic cup structure. This filtering feature can be configured as a ring of inwardly and proximally projecting filter posts that force liquid product through interstitial filter openings 1350 and filter out coagulated or congealed product, larger particles etc. ("solids") and prevent those solids from clogging the swirl inducing channels. The cup configuration defines an inner ring-shaped volume which receives the filtered liquid and feeds the fluidic channels. Thus multiple filter openings 1350 are available and liquid product flow will not be interrupted even if some of the filter openings become temporarily clogged. In the example illustrated FIGS. 20A and 20B twelve radially arrayed and equal area filter openings 1350 are defined between the filter post members and so even with a few openings clogged, the others remain available and in continuous fluid communication with the discharge orifice 1380.

Turning now to the filter cup embodiments of FIGS. 21A and 21B, these are diagrams illustrating another one-piece, unitary filtered fluidic cup oscillator nozzle member 1400 configured with a plurality of (e.g., twelve) integral proximally projecting filter post members (1440A-1440L) which are spaced apart and arrayed around fluidic oscillator inducing features 1420, 1422, 1424 molded into the cup's interior surfaces, with a substantially circular discharge orifice or exit lumen 1430, where the two opposing venturi-shaped power nozzles 1422, 1424 are aimed at the interaction region 1420. The spaced proximally projecting filter post members (1440A-1440L) define a filtering region with lumens or filter openings **1450** therebetween so that pressurized fluid (e.g., liquid or foam) flowing into the nozzle assembly flows between the filter post members via inter-post filtering lumens **1450** and into a ring shaped volume **1452** which is in fluid communication with fluid oscillation inducing features **1420**, **1422**, **1424** and discharge orifice **1430** so that filtered fluid flows and the nozzle sprays without adverse effects caused by fluid product clogs.

Filtered fluidic cup **1400** is preferably configured as a one-piece injection-molded plastic fluidic cup-shaped conformal nozzle and does not require a multi-component insert and housing assembly. The fluidic oscillator's operative features or geometry **1410** are preferably molded directly into the cup's interior surfaces and the cup is configured for easy installation to an actuator body (e.g., **340**). This eliminates the need for multi-component fluidic cup assembly made from a fluidic circuit defining insert which is received within a cup-shaped member's cavity (as in the embodiments of FIGS. **9**A-**11**D). The filtered fluidic cup embodiment illustrated in FIGS. **21**A and **21**B provide a novel filtered fluidic circuit which functions like a planar fluidic circuit but which has the fluidic circuit's oscillation inducing features and geometry **1410** molded in-situ within a cup-shaped member so that once installed on an actuator's fluid impermeable, resilient support member (e.g., such as sealing post **320**) a sealed conduit is created and a complete and effective fluidic oscillator nozzle is provided. The (preferably) circular (0.25 mm diameter) exit or discharge port **1430** is in fluid communication and receives fluid from interaction region **1420**. The opposing tapered venturi-shaped power nozzles **1422** and **1424** and interaction region **1420** are preferably molded in-situ within the interior surface of distal end-wall **1480**. The molded interior surface of circular, planar or disc-shaped end wall **1480** includes grooves or troughs defining the two channel oscillation-inducing geometry **1410** and is carried within the substantially cylindrical sidewall segment **1490**, which has an open proximal end **1492** and a closed distal end including a distal surface having substantially centered circular distal port or throat **1430** defined therethrough so that discharge port **1430** is aimed distally. One-piece filtered fluidic nozzle member **1400** is optionally configured with first and second parallel opposing substantially planar "wrench-flat" segments (not shown) defined in cylindrical sidewall segment **1490**.

It will be appreciated by those with skill in the art that filtered fluidic cup member **1400** includes a new filtering feature integrally molded within the fluidic cup structure. This filtering feature can be configured as a ring of inwardly and proximally projecting filter posts that force liquid product through interstitial filter openings **1450** and filter out coagulated or congealed product, larger particles etc. ("solids") and prevent those solids from clogging the fluidic channels. The cup configuration defines an inner ring-shaped volume which receives the filtered liquid and feeds the fluidic channels. Thus multiple filter openings **1450** are available and liquid product flow will not be interrupted even if some of the filter openings become temporarily clogged. In the example illustrated in FIGS. **21**A and **21**B, twelve radially arrayed and equal area filter openings are defined between the filter post members and so even with a few openings clogged, the others remain available and in continuous fluid communication with the discharge orifice **1430**.

The filter post geometry in filtered fluidic cup **1400** has been modified from that illustrated for filtered fluidic cup **1200** to adjust the size and distribution of the spray. The configuration of the ring of filter posts (**1440**A-**1440**L) has been observed to have a significant effect on spray quality. In the embodiment illustrated in FIGS. **21**A and **21**B, the size of the filter posts has been in reduced from those illustrated in FIGS. **19**A and **19**B to optimize fit with a commercially available mating part (e.g., similar to sealing post **320**) which seals the fluidic geometry & completes the filtration system. The fluidic channel length has been increased from approximately Twice the Depth of Channel to Three times (3×) the Depth of Channel. Two changes were required to make room for the longer channel. First, the radii at the entrance of the channel were reduced; and second, the width of the inner ring was reduced locally at the entrance of the channel. Manufacturing limitations prevented the width of the inner ring from being reduced uniformly across its circumference. As a result, the inwardly projecting elements defining the previously circular fluidic geometry of FIGS. **19**A and **19**B (**1220**, **1222**, **1224**) now resemble an oval shape (defining **1420**, **1422**, **1424**).

It will be appreciated that the filtered cups **1200**, **1300** and **1400** and the method of the present invention for using these structures readily conform to the industry-standard actuator stem used in typical aerosol sprayers and trigger sprayers and so replaces the prior art "swirl cup" that goes over the actuator stem (e.g., **320**), and the benefits of using a filter structure (e.g., proximally projecting filter post members (**1240**A-**1240**L) are made available with little or no significant changes to other parts of the industry standard liquid product packaging. With the filter cup embodiments and method of the present invention, vendors of liquid products and fluids sold in commercial aerosol sprayers and trigger sprayers can now provide very reliable filtered clog-free sprays in selected spray patterns (e.g., **650** or **850**).

It will be appreciated by persons having skill in the art that the filter post features defining the a filtering regions illustrated in FIGS. **19**A-**21**B can be configured for use with the other nozzle assemblies or spray heads described above (e.g., those illustrated in FIGS. **7**A-**15**), so a filter array or filtering region can be incorporated into sprayers **900** or **1000** with conformal, fluid nozzle components such as **1200**, **1300**, **1400** which are configured to generate a filtered spray discharged from a substantially closed distal end wall with a centrally located discharge orifice **1230**, **1330**, **1430** defined therein. Optionally, a cup-shaped filtered orifice defining member may also include a fluidic circuit's oscillation inducing geometry (**1420**, **1422**, **1424**) molded into the cup or directly into the distal surface of a nozzle assembly's or spray head's sealing post **902**, **1002** with filter posts such that the filter cup provides the discharge orifice (e.g., **930**, **1030**, **1230**, **1330**, **1430**).

Having described preferred embodiments of a new and improved nozzle assembly and method, it is believed that other modifications, variations and changes will be suggested to those skilled in the art in view of the teachings set forth herein. It is therefore to be understood that all such variations, modifications and changes are believed to fall within the scope of the appended claims which define the present invention.

We claim:

1. A filtering nozzle assembly or spray head including a lumen or duct for dispensing or spraying a pumped or pressurized liquid product or fluid from a valve, pump or actuator assembly drawing from a transportable container to generate a spray of fluid droplets, comprising;

(a) an actuator body having a distally projecting sealing post having a post peripheral wall terminating at a distal or outer face, said actuator body including a fluid passage communicating with said lumen;

(b) a cup-shaped filtered orifice defining member mounted in said actuator body having a peripheral wall extending proximally into a bore in said actuator body radially outwardly of said sealing post and having a distal radial wall comprising an inner face opposing said sealing post's distal or outer face to define a fluid channel including a chamber between said body's sealing post and said cup-shaped member's peripheral wall and distal wall;

(c) said chamber being in fluid communication with said actuator body's fluid passage to define a fluid filter inlet so said pressurized fluid may enter said fluid channel's chamber and filtering region;

(d) said cup-shaped member distal wall's inner face is configured to define within said chamber a plurality of proximally projecting filter posts with a first proximally projecting filter post and a second proximally projecting filter post, wherein said proximally projecting filter posts are radially arrayed and spaced apart to define inter-post filtering lumens therebetween for filtering passing pressurized fluid flowing through said chamber to provide a filtered fluid flow; and

(e) wherein said chamber is in fluid communication with a discharge orifice defined in said cup-shaped member's distal wall, and said filtered fluid flow exhausts from said discharge orifice as spray of fluid droplets in a selected spray pattern.

2. The filtering nozzle assembly of claim **1**, wherein said cup-shaped filtered orifice defining member's distal end wall's power nozzle is defined between first and second distally projecting substantially parallel elongated alignment tabs or orientation ribs.

3. The filtering nozzle assembly of claim **1**, wherein said cup-shaped filtered orifice defining member's filter posts are molded directly into said cup's interior wall segments and the cup-shaped filtered orifice defining member is thus configured to be economically fitted onto the sealing post.

4. The filtering nozzle assembly of claim **3**, wherein said sealing post's distal or outer face has a substantially flat and fluid impermeable outer surface in flat face sealing engagement with the cup-shaped member's inwardly projecting filter posts.

5. The filtering nozzle assembly of claim **4**, wherein said distally projecting sealing post's peripheral wall and said cup-shaped filtered orifice defining member's peripheral wall are spaced axially to define said fluid channel as an annular lumen and are generally coaxially aligned with each other.

6. The filtering nozzle assembly of claim **1**, wherein said nozzle assembly is configured with a hand operated pump in a trigger sprayer configuration.

7. The filtering nozzle assembly of claim **1**, wherein said nozzle assembly is configured with propellant pressurized aerosol container with a valve actuator.

8. The filtering nozzle assembly of claim **1**, wherein said cup-shaped filtered orifice defining member is configured as a conformal, unitary, one-piece fluidic circuit configured for easy and economical incorporation into a trigger spray nozzle assembly or aerosol spray head actuator body including distally projecting sealing post and a lumen for dispensing or spraying a pressurized liquid product or fluid from a transportable container to generate an exhaust flow in the form of an oscillating spray of fluid droplets, comprising;

(a) a cup-shaped fluidic circuit member having a peripheral wall extending proximally and having a distal radial wall comprising an inner face with features defined therein and an open proximal end configured to receive an actuator's sealing post;

(b) said cup-shaped member's peripheral wall and distal radial wall having inner surfaces comprising a fluid channel including a chamber when said cup-shaped member is fitted to body's sealing post;

(c) said chamber being configured to define a fluidic circuit oscillator inlet in fluid communication with an interaction region so when said cup-shaped member is fitted to body's sealing post and pressurized fluid is introduced via said actuator body, the pressurized fluid may enter said fluid channel's chamber and interaction region and generate at least one oscillating flow vortex within said fluid channel's interaction region;

(d) wherein said cup shaped member's distal wall includes a discharge orifice in fluid communication with said chamber's interaction region, and

(e) wherein said cup-shaped fluidic circuit's distal end wall's discharge orifice is defined between first and second distally projecting substantially parallel elongated alignment tabs or orientation ribs.

9. The filtering nozzle assembly of claim **8**, wherein said chamber is configured so that when said cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via said actuator body, said chamber's fluidic oscillator inlet is in fluid communication with a first power nozzle and second power nozzle, wherein said first power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through said first nozzle to form a first jet of fluid flowing into said chamber's interaction region, and said second power nozzle is configured to accelerate the movement of passing pressurized fluid flowing through said second nozzle to form a second jet of fluid flowing into said chamber's interaction region, and wherein said first and second jets impinge upon one another at a selected inter-jet impingement angle and generate oscillating flow vortices within said fluid channel's interaction region.

10. The filtering nozzle assembly of claim **9**, wherein said chamber is configured so that when said cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via said actuator body, said chamber's interaction region is in fluid communication with said discharge orifice defined in said fluidic circuit's distal wall, and said oscillating flow vortices exhaust from said discharge orifice as an oscillating spray of substantially uniform fluid droplets in a selected spray pattern having a selected spray width and a selected spray thickness.

11. The filtering nozzle assembly of claim **10**, wherein said first and second power nozzles comprise venturi-shaped or tapered channels or grooves in said distal wall's inner face.

12. The filtering nozzle assembly of claim **11**, wherein said first and second power nozzles terminate in a rectangular or box-shaped interaction region defined in said distal wall's inner face.

13. The filtering nozzle assembly of claim **12**, wherein said first and second power nozzles terminate in a cylindrical interaction region defined in said distal wall's inner face.

14. The filtering nozzle assembly of claim **10**, wherein said selected inter-jet impingement angle is 180 degrees and said chamber is configured so that when said cup-shaped member is fitted to the body's sealing post and pressurized fluid is introduced via said actuator body, said oscillating flow vortices are generated within said fluid channel's interaction region by opposing jets.

15. The filtering nozzle assembly of claim **10**, wherein said nozzle assembly is configured with a hand operated pump in a trigger sprayer configuration.

16. The filtering nozzle assembly of claim **10**, wherein said nozzle assembly is configured with propellant pressurized aerosol container with a valve actuator.

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